

# SETUP & OPERATION MANUAL

## FEATURES

- Large surface, ground cast-iron tables for stability and added support when feeding longer stock.
- Heavy-duty, three-knife cutter head for clean, fast, superior finish cuts.
- Jackscrew system for quick, easy knife adjustment.
- Large, heavy-duty, center-mounted cast-iron fence with 90° and 45° positive stops.
- Independent in-feed and out-feed table adjustment handwheels.  
(Models 80-075L & 80-100L/LHC)
- Quick lever in-feed table adjustment.  
(Model 80-150L/LHC)
- 4" dust collection outlet included.
- Built-in rabbeting ledge.  
(Models 80-100L/LHC & 80-150L/LHC)
- 2 hand-paddle style push blocks included.
- On-board push block storage mounts.
- Extra long 55 1/4" tables.
- Large paddle-style stop switch.

## SPECIFICATIONS

### TABLE SIZE

7 1/4" x 55 1/4" (184 x 1403 mm)

### MAXIMUM CUTTING WIDTH

6" (152 mm)

### MAXIMUM CUTTING DEPTH

1/2" (13 mm)

### RABBETING CAPACITY

1/2" (13 mm)

### FENCE SIZE

4" x 29" (102 x 737 mm)

### CUTTER HEAD SPEED

5000 RPM

### NUMBER OF KNIVES

3/HELICAL

### BASE DIMENSIONS (L X W)

25 3/4" x 22" (654 x 559 mm) - 80-075L

24" x 14" (610 x 356 mm) - 80-100L/LHC & 80-150L/LHC

### MOTOR

1 HP, 110/220 V, 13/7 A

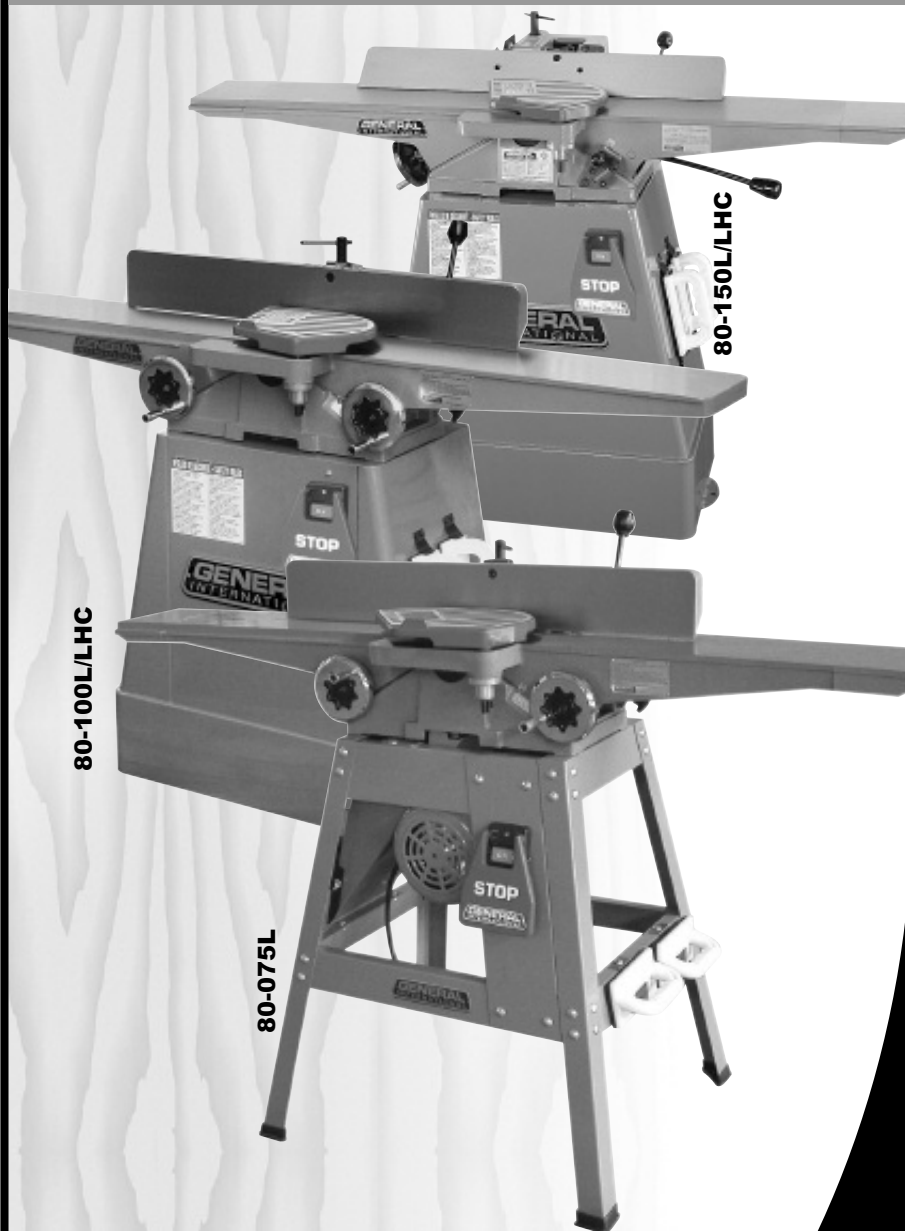
### WEIGHT

235 LBS (107 kg) - 80-075L

249 LBS (113 kg) - 80-100L/LHC &

80-150L/LHC

## 6" DELUXE JOINTER



# MODEL

## #80-075L

## #80-100L/LHC

## #80-150L/LHC





**GENERAL® INTERNATIONAL**

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**THANK YOU** for choosing this General® International model 80-075L, 80-100L/LHC or 80-150L/LHC 6" Deluxe Jointer. This jointer has been carefully tested and inspected before shipment and if properly used and maintained, will provide you with years of reliable service. To ensure optimum performance and trouble-free operation, and to get the most from your investment, please take the time to read this manual before assembling, installing and operating the unit.

The manual's purpose is to familiarize you with the safe operation, basic function, and features of this jointer as well as the set-up, maintenance and identification of its parts and components. This manual is not intended as a substitute for formal woodworking instruction, nor to offer the user instruction in the craft of woodworking. If you are not sure about the safety of performing a certain operation or procedure, do not proceed until you can confirm, from knowledgeable and qualified sources, that it is safe to do so.

Once you've read through these instructions, keep this manual handy for future reference.

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**Disclaimer:** The information and specifications in this manual pertain to the unit as it was supplied from the factory at the time of printing. Because we are committed to making constant improvements, General® International reserves the right to make changes to components, parts or features of this unit as deemed necessary, without prior notice and without obligation to install any such changes on previously delivered units. Reasonable care is taken at the factory to ensure that the specifications and information in this manual corres-

ponds with that of the unit with which it was supplied. However, special orders and "after factory" modifications may render some or all information in this manual inapplicable to your machine. Further, as several generations of this model of jointer and several versions of this manual may be in circulation, if you own an earlier or later version of this unit, this manual may not depict your machine exactly. If you have any doubts or questions contact your retailer or our support line with the model and serial number of your unit for clarification.

# GENERAL® & GENERAL® INTERNATIONAL WARRANTY

All component parts of General®, General® International and Excalibur by General International® products are carefully inspected during all stages of production and each unit is thoroughly inspected upon completion of assembly.

## Limited Lifetime Warranty

Because of our commitment to quality and customer satisfaction, General® and General® International agree to repair or replace any part or component which upon examination, proves to be defective in either workmanship or material to the original purchaser for the life of the tool. *However, the Limited Lifetime Warranty does not cover any product used for professional or commercial production purposes nor for industrial or educational applications. Such cases are covered by our Standard 2-year Limited Warranty only. The Limited Lifetime Warranty is also subject to the "Conditions and Exceptions" as listed below.*

## Standard 2-Year Limited Warranty

All products not covered by our lifetime warranty including products used in commercial, industrial and educational applications are warranted for a period of 2 years (24 months) from the date of purchase. General® and General® International agree to repair or replace any part or component which upon examination, proves to be defective in either workmanship or material to the original purchaser during this 2-year warranty period, subject to the "conditions and exceptions" as listed below.

## To file a Claim

To file a claim under our Standard 2-year Limited Warranty or under our Limited Lifetime Warranty, all defective parts, components or machinery must be returned freight or postage prepaid to General® International, or to a nearby distributor, repair center or other location designated by General® International. For further details call our service department at 1-888-949-1161 or your local distributor for assistance when filing your claim.

Along with the return of the product being claimed for warranty, a copy of the original proof of purchase and a "letter of claim" must be included (a warranty claim form can also be used and can be obtained, upon request, from General® International or an authorized distributor) clearly stating the model and serial number of the unit (if applicable) and including an explanation of the complaint or presumed defect in material or workmanship.

## **CONDITIONS AND EXCEPTIONS:**

This coverage is extended to the original purchaser only. Prior warranty registration is not required but documented proof of purchase i.e. a copy of original sales invoice or receipt showing the date and location of the purchase as well as the purchase price paid, must be provided at the time of claim.

Warranty does not include failures, breakage or defects deemed after inspection by General® or General® International to have been directly or indirectly caused by or resulting from; improper use, or lack of or improper maintenance, misuse or abuse, negligence, accidents, damage in handling or transport, or normal wear and tear of any generally considered consumable parts or components.

***Repairs made without the written consent of General® International will void all warranty.***

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# RULES FOR SAFE OPERATION

**To help ensure safe operation, please take a moment to learn the machine's applications and limitations, as well as potential hazards. General® International disclaims any real or implied warranty and holds itself harmless for any injury that may result from improper use of its equipment.**

1. Do not operate this jointer when tired, distracted, or under the effects of drugs, alcohol or any medication that impairs reflexes or alertness.
2. The working area should be well lit, clean and free of debris.
3. Keep children and visitors at a safe distance when the jointer is in operation; do not permit them to operate the jointer.
4. Childproof and tamper proof your shop and all machinery with locks, master electrical switches and switch keys, to prevent unauthorized or unsupervised use.
5. **Stay alert!** Give your work your undivided attention. Even a momentary distraction can lead to serious injury.
6. Fine particulate dust is a carcinogen that can be hazardous to health. Work in a well-ventilated area and whenever possible use a dust collector. Wear face, eye, ear, respiratory and body protection devices.
7. Do not wear loose clothing, gloves, bracelets, necklaces or other jewelry while the jointer is in operation. Wear protective hair covering to contain long hair and wear non-slip footwear.
8. Be sure that adjusting wrenches, tools, drinks and other clutter are removed from the machine and/or the table surface before operating.
9. Keep hands well away from knives and all moving parts. Use a push stick to feed stock, and a brush, not hands, to clear away chips and dust.
10. Be sure that the knives are securely installed in the cutterhead.
11. Always use clean, properly sharpened knives. Dirty or dull knives are unsafe and can lead to accidents.
12. If using a power feeder, stop the feeder before stopping the jointer.
13. Do not push or force stock into the cutter head. The jointer will perform better and more safely when working at the rate for which it was designed.
14. Be sure that the cutter head has gained full operating speed before starting to joint.
15. Avoid working from awkward or off balance positions. Do not overreach and keep both feet on floor.
16. Keep guards in place and in working order. If a guard must be removed for maintenance or cleaning be sure it is properly re-attached before using the tool again.
17. Use of parts and accessories NOT recommended by GENERAL® INTERNATIONAL may result in equipment malfunction or risk of injury.
18. Never stand on machinery. Serious injury could result if the tool is tipped over or if the cutting tool is unintentionally contacted.
19. Always disconnect the tool from the power source before servicing or changing accessories such as knives, or before performing any maintenance or cleaning, or if the machine will be left unattended.
20. Make sure that the switch is in the "OFF" position before plugging in the power cord.
21. Make sure the tool is properly grounded. If equipped with a 3-prong plug it should be used with a three-pole receptacle. Never remove the third prong.
22. Do not use this jointer for other than its intended use. If used for other purposes, GENERAL® INTERNATIONAL disclaims any real implied warranty and holds itself harmless for any injury, which may result from that use.



# Additional Safety Instructions for Jointers



Because each shop situation is unique, no list of safety guidelines can ever be complete.

The most important safety feature of any shop is the knowledge and good judgement of the user. Use common sense and always keep safety considerations, as they apply to your individual shop conditions, first and foremost in mind. If you have any doubts about the safety of an operation you are about to perform: STOP! Do not perform the operation until you have validated from qualified individuals if the operation is safe to perform and what is the safest method to perform it.

## 1. WORK PIECE KICKBACK

Kickback is when the work piece is ejected at high speeds from the jointer table by the force of the cutter head. To minimize the risk of injury from kickback, always use push blocks and wear safety glasses. Do not operate this machine if you do not understand kickback, its causes and how to avoid it.

## 2. CUTTER HEAD ALIGNMENT

To reduce the risk of injury and to avoid kickback, keep the top edge of the outfeed table aligned with the top dead center edge of the knife.

## 3. PUSH BLOCKS

Always use push blocks when jointing. Never pass your bare hands directly over the cutter head without a push block to hold and guide the workpiece.

## 4. WORKPIECE SUPPORT

To make safe cuts and reduce the risk of injury, support the workpiece adequately at all times. Never attempt to make a cut with an unstable workpiece.

## 5. KICKBACK ZONE

The kickback zone on a jointer is the area directly in the path through and off of the end of the infeed table. Never stand or allow others to stand in this area during operation.

## 6. MAXIMUM DEPTH OF CUT

The maximum depth of cut for one pass is 1/8". Never attempt to remove more material than 1/8" in any single pass.

## 7. JOINTING WITH THE GRAIN

Jointing against the grain or jointing end grain is dangerous and could produce chatter or excessive chip out. Always joint with the grain.

## 8. KEEPING GUARDS IN PLACE

Except when rabbeting, all operations must be performed with the guard in place. After rabbeting, be sure to replace the guard.

## 9. PROPER CUTTING

Always move the work piece over the cutter head from the infeed table towards the outfeed table until the work piece has passed completely over the cutter head. Never back the work piece towards the infeed table.

## 10. USING GOOD WORK PIECE STOCK

Jointing safety begins with the stock used with the machine. Inspect the work piece carefully before jointing it. Never joint a board that has loose knots, staples, nails or other embedded foreign objects. If you have the slightest doubt about the structural integrity or stability of a board: Do Not Joint It.

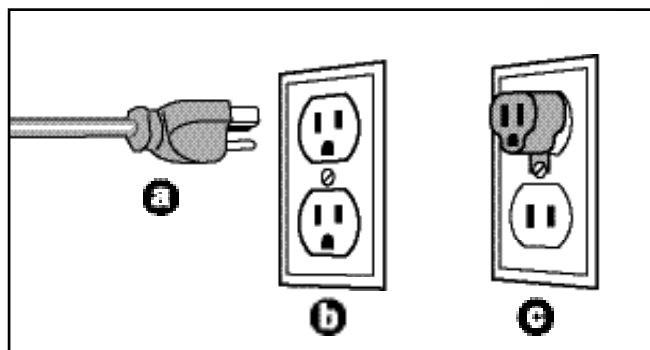


# ELECTRICAL REQUIREMENTS



BEFORE CONNECTING THE MACHINE TO THE POWER SOURCE, VERIFY THAT THE VOLTAGE OF YOUR POWER SUPPLY CORRESPONDS WITH THE VOLTAGE SPECIFIED ON THE MOTOR I.D. NAMEPLATE. A POWER SOURCE WITH GREATER VOLTAGE THAN NEEDED CAN RESULT IN SERIOUS INJURY TO THE USER AS WELL AS DAMAGE TO THE MACHINE. IF IN DOUBT, CONTACT A QUALIFIED ELECTRICIAN BEFORE CONNECTING TO THE POWER SOURCE.

THIS TOOL IS FOR INDOOR USE ONLY. DO NOT EXPOSE TO RAIN OR USE IN WET OR DAMP LOCATIONS.



## GROUNDING INSTRUCTIONS

In the event of an electrical malfunction or short circuit, grounding reduces the risk of electric shock. The motor of this machine is wired for 110V single phase operation and is equipped with a 3-conductor cord and a 3-prong grounding plug **(a)** to fit a grounded type receptacle **(b)**. Do not remove the 3rd prong (grounding pin) to make it fit into an old 2-hole wall socket or extension cord. If an adaptor plug is used **(c)**, it must be attached to the metal screw of the receptacle.

*Note: The use of an adaptor plug is illegal in some areas. Check your local codes. If you have any doubts or if the supplied plug does not correspond to your electrical outlet, consult a qualified electrician before proceeding.*

## CIRCUIT CAPACITY

Make sure that the wires in your circuit are capable of handling the amperage draw from your machine, as well as any other machines that could be operating on the same circuit. If you are unsure, consult a qualified electrician. If the circuit breaker trips or the fuse blows regularly, your machine may be operating on a circuit that is close to its amperage draw capacity. However, if an unusual amperage draw does not exist and a power failure still occurs, contact a qualified technician or our service department.

## CONVERTING THE MOTOR TO 220V

Should you need to convert your machine's motor from 110V to 220V power, there is an electrical schematic drawing on the inside of the motor cover plate. Unless you are a qualified electrician, we do not recommend attempting this conversion on your own. If you choose to do so, you may risk serious personal injury, damage to the motor and voiding the warranty of your machine.

We suggest you ask your local General International distributor to recommend qualified electricians in your area (or perhaps one of their own technicians) who can make this conversion properly and safely.

## EXTENSION CORDS

If you find it necessary to use an extension cord with your machine, use only 3-wire extension cords that have 3-prong grounding plug and a matching 3-pole receptacle that accepts the tool's plug. Repair or replace a damaged extension cord or plug immediately.

Make sure the cord rating is suitable for the amperage listed on the motor I.D. plate. An undersized cord will cause a drop in line voltage resulting in loss of power and overheating. The accompanying chart shows the correct size extension cord to be used based on cord length and motor I.D. plate amp rating. If in doubt, use the next heavier gauge. The smaller the number, the heavier the gauge.

TABLE - MINIMUM GAUGE FOR CORD					
AMPERE RATING	TOTAL LENGTH OF CORD IN FEET				
	110 VOLTS	25 FEET	50 FEET	100 FEET	150 FEET
	220 VOLTS	50 FEET	100 FEET	200 FEET	300 FEET
AWG					
< 5	----->	18	16	16	14
6 TO 10	----->	18	16	14	12
10 TO 12	----->	16	16	14	12
12 TO 16	----->	14	12	* NR	* NR
* NR = Not Recommended					



## 6" DELUXE JOINTER

80-075L, 80-100L/LHC & 80-150L/LHC

# BASIC FUNCTIONS

This 6" jointer is designed for face and edge jointing in solid wood only. The unit is not designed nor should it be used to surface or prepare, plywood, wood panelling, particleboard, MDF nor any other wood based by-products nor any non-wood based materials.

This 6" jointer is offered in 3 different formats with 2 different cutterhead options as follows:

- **Model 80-075L M1** - 6" jointer with standard 3-knife cutter head and an open base stand and handwheel controlled infeed and outfeed table height adjustments.
- **Model 80-100L M1** - 6" jointer with standard 3-knife cutter head, a closed based stand and handwheel controlled infeed and outfeed table height adjustments.
- **Model 80-100LHC M1** - 6" jointer with magnum helical cutterhead with reversible carbide inserts, a closed based stand and handwheel controlled infeed and outfeed table height adjustments.
- **Model 80-150L M1** - 6" jointer with standard 3-knife cutter head, a closed based stand and hand lever controlled infeed and handwheel controlled outfeed table height adjustments.
- **Model 80-100LHC M1** - 6" jointer with magnum helical cutterhead with reversible carbide inserts, a closed based stand and handwheel controlled infeed and outfeed table height adjustments.

# PLACEMENT WITHIN THE SHOP / ESTABLISHING A SAFETY ZONE



**THIS JOINTER IS HEAVY - 235 LBS (107 KG) FOR MODEL 80-075L AND 249 LBS (113 KG) FOR MODELS 80-100L/LHC & 80-150L/LHC. DO NOT OVER-EXERT. THE HELP OF AN ASSISTANT WILL BE NEEDED FOR THE FOLLOWING STEP.**

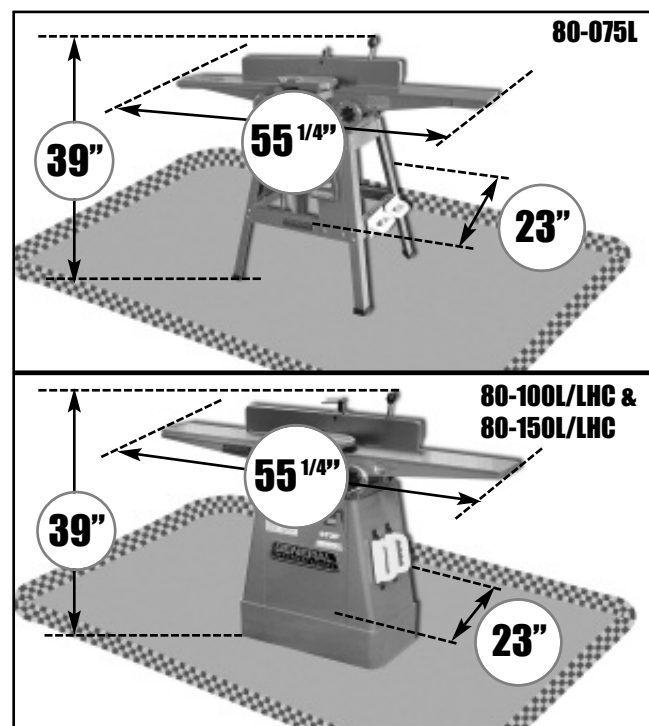
## PLACEMENT WITHIN THE SHOP

This machine should be installed and operated only on a solid, flat and stable floor that is able to support the weight of the jointer and the operator.

Using the dimensions shown as a guideline, plan for placement within your shop that will allow the operator to work unencumbered and unobstructed by foot traffic (either passing shop visitors or other shop workers) or other tools or machinery.

## ESTABLISHING A SAFETY ZONE

For shops with frequent visitors or multiple operators, it is advisable to establish a safety zone around shop machinery. A clearly defined "no-go" zone on the floor around each machine can help avoid accidents that could cause injury to either the operator or the shop visitor. It is advisable to take a few moments to either paint (using non-slip paint) or using tape, define on the floor the limits or perimeter of each machines safety zone. Take steps to ensure that all operators and shop visitors are aware that these areas are off limits whenever a machine is running for everyone but the individual operating the unit.



# UNPACKING - MODEL 80-075L ONLY

Carefully unpack and remove the jointer, its components and tools from its shipping container and check for missing or damaged items as per the list of contents below.

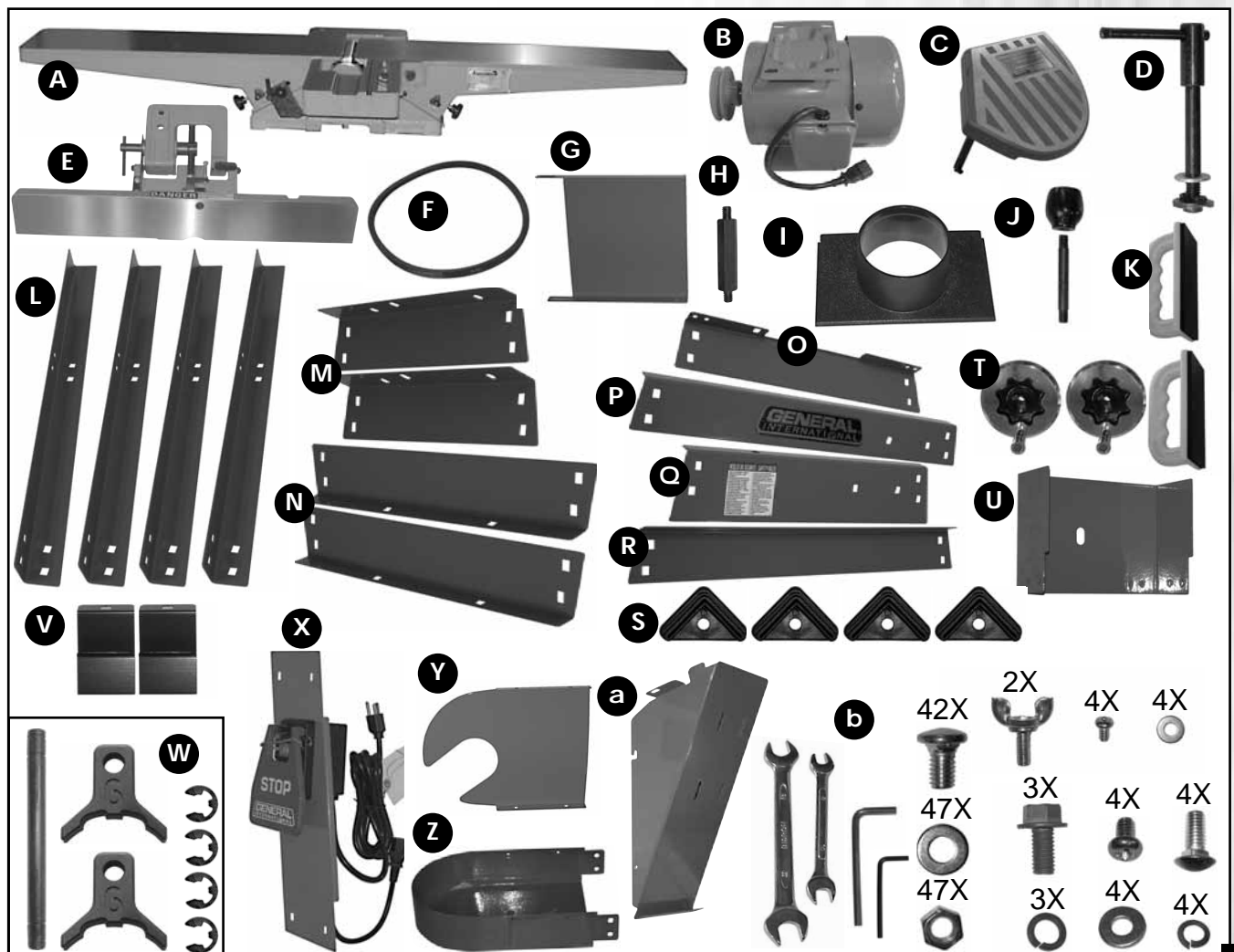
**NOTE:** Please report any damaged or missing items to your GENERAL® INTERNATIONAL distributor immediately.

## LIST OF CONTENTS

## QTY

A - JOINTER BED .....	1
B - MOTOR .....	1
C - CUTTER HEAD GUARD ASSEMBLY .....	1
D - FENCE LOCKING HANDLE .....	1
E - FENCE .....	1
F - V BELT .....	1
G - DUST PORT MOUNTING BRACKET .....	1
H - PULLEY GUARD STUD .....	1
I - DUST PORT .....	1
J - FENCE TILT LEVER / HANDLE .....	1
K - PUSH BLOCK .....	2
L - STAND LEG .....	4
M - STAND UPPER TOP SHELF .....	2
N - STAND SIDE CROSS BRACE .....	2
O - STAND REAR TOP SHELF .....	1
P - STAND FRONT CROSS BRACE .....	1
Q - STAND FRONT TOP SHELF .....	1
R - STAND REAR CROSS BRACE .....	1
S - STAND RUBBER FOOT .....	4
T - TABLE HEIGHT ADJUSTMENT HANDWHEEL .....	2
U - UPPER PULLEY GUARD .....	1

V - FENCE STORAGE BRACKETS .....	2
W - KNIFE SETTING GAUGE .....	1
X - SWITCH .....	1
Y - LOWER PULLEY GUARD BACKER PLATE .....	1
Z - LOWER PULLEY GUARD COVER .....	1
a - MOTOR MOUNTING BRACKET .....	1
b - HARDWARE & TOOLS	
12 - 14 MM OPEN END WRENCH .....	1
8 - 10 MM OPEN END WRENCH .....	1
4 MM ALLEN KEY .....	1
3 MM ALLEN KEY .....	1
SHORT CARRIAGE BOLT .....	42
FLAT WASHER (WITH LARGE HOLE) .....	47
HEX NUT .....	47
WING SCREW .....	2
FLANGE BOLT .....	3
LARGE LOCK WASHER .....	3
SMALL PHILLIPS SCREW .....	4
SMALL FLAT WASHER .....	4
PAN HEAD PHILLIPS SCREW .....	4
FLAT WASHER (WITH SMALL HOLE) .....	4
LONG CARRIAGE BOLT .....	4
SMALL LOCK WASHER .....	4



# UNPACKING - MODELS 80-100L/LHC & 80-150L/LHC ONLY

Carefully unpack and remove the jointer, its components and tools from its shipping container and check for missing or damaged items as per the list of contents below.

**NOTE:** Please report any damaged or missing items to your GENERAL® INTERNATIONAL distributor immediately.

## LIST OF CONTENTS

## QTY

A - JOINTER BED	1
B - FENCE	1
C - PULLEY GUARD	1
D - CUTTER HEAD GUARD ASSEMBLY	1
E - BASE	1
F - DUST PORT <sup>1</sup>	1
G - V-BELT <sup>1</sup>	1
H - PUSH BLOCK	2
I - TABLE HEIGHT ADJUSTMENT HANDWHEEL <sup>1</sup>	2
J - FENCE TILT LEVER/HANDLE <sup>2</sup>	2
K - BASE DOOR <sup>1</sup>	2
L - IN-FEED TABLE HEIGHT ADJUSTMENT LEVER	1
M - FENCE LOCKING HANDLE <sup>3</sup>	1
N - KNIFE SETTING GAUGE <sup>4</sup>	1
O - HELICAL CUTTER HEAD TOOLS/REPLACEMENT PARTS <sup>5</sup>	
5 MM T ALLEN KEY	1
5 MM ALLEN KEY	1
NUT	2
SCREW	2
KNIFE-HOLDER / CHIP-BREAKER	2
CARBIDE INSERT (STANDARD)	2
CARBIDE INSERT (FOR RABBETING)	1

## P - TOOLS

12-14 MM OPEN END WRENCH	1
8-10 MM OPEN END WRENCH	1
3 MM ALLEN KEY	1

## Q - HARDWARE

14 MM FLANGE BOLT	3
LOCK WASHER	3
PHILLIPS SCREW	4
FLAT WASHER	4

## R - HARDWARE<sup>1</sup>

SMALL PHILLIPS SCREW	4
SMALL FLAT WASHER	4
PHILLIPS SCREW	4
FLAT WASHER	4

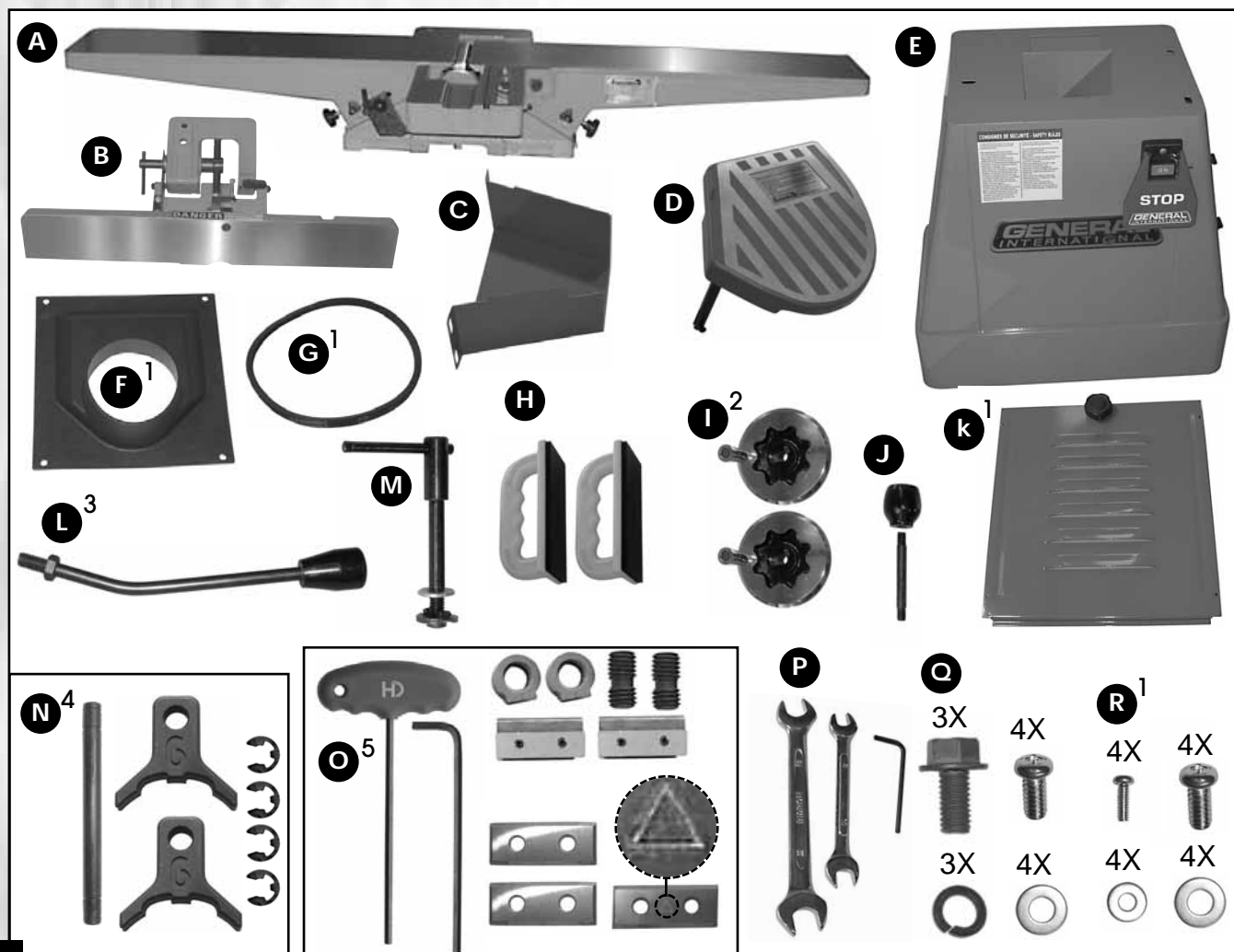
<sup>1</sup> Stored inside the base

<sup>2</sup> Only one supplied with model 80-150L/LHC

<sup>3</sup> Model 80-150L/LHC

<sup>4</sup> Not supplied with models 80-100LHC & 80-150LHC

<sup>5</sup> Supplied with models 80-100LHC & 80-150LHC only



# CLEAN UP

The protective coating on the jointer tables prevents rust from forming during shipping and storage. Remove it by rubbing with a rag dipped in kerosene, mineral spirits or paint thinner. (Dispose of potentially flammable solvent-soaked rags according to manufacturer's safety recommendations.)

A putty knife, held flat to avoid scratching the surface, may also be used to scrape off the coating followed by clean-up with solvent. Avoid rubbing the saw's painted surfaces, as many solvent-based products will remove paint.

To prevent rust, apply a light coating of paste wax or use regular applications of any after-market surface protectant or rust inhibitor.

# ASSEMBLY INSTRUCTIONS



**SERIOUS PERSONAL INJURY COULD OCCUR IF YOU CONNECT THE MACHINE TO THE POWER SOURCE BEFORE YOU HAVE COMPLETED THE INSTALLATION AND ASSEMBLY STEPS. DO NOT CONNECT THE MACHINE TO THE POWER SOURCE UNTIL INSTRUCTED TO DO SO.**

## STAND ASSEMBLY - MODEL 80-075L ONLY

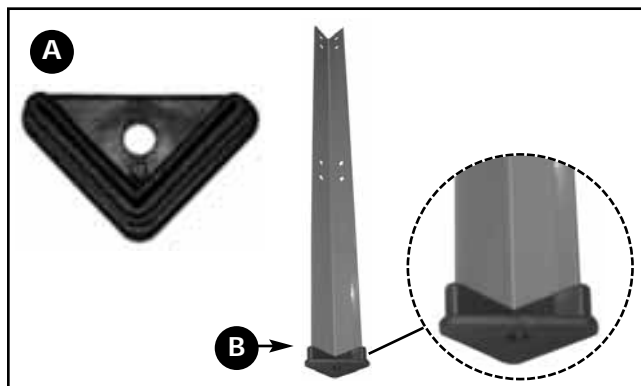
### Hardware Needed:

	Qty
Short carriage bolt	.32
Flat washer (with large hole)	.32
Hex nut	.32

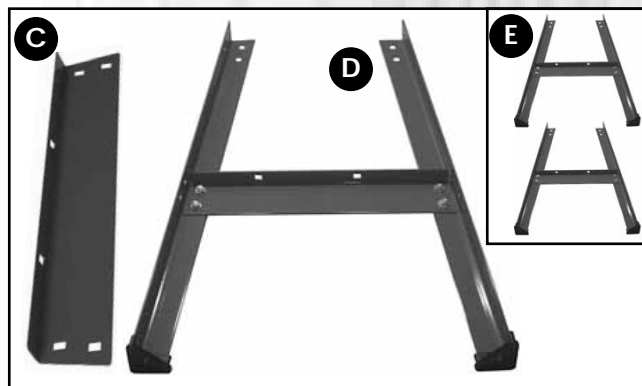
32X



*Note: Only hand-tighten the nuts for now. Final tightening will be done once the jointer bed has been secured to the stand.*



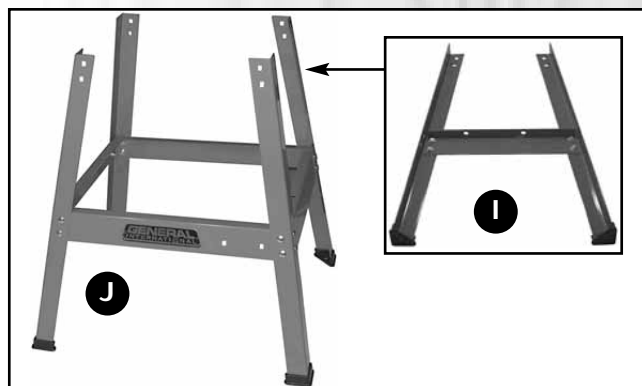
1. Fit one rubber foot A onto the bottom end (without holes) of all four stand legs B.



2. Attach one side cross brace C to 2 stand legs as shown in D. Repeat with the other side cross brace and 2 other legs E.



3. Attach the front cross brace F and rear cross brace G to one of the side cross brace/leg assembly as shown in H.



4. Attach the second side cross brace/leg assembly I to the main stand assembly as shown in J.

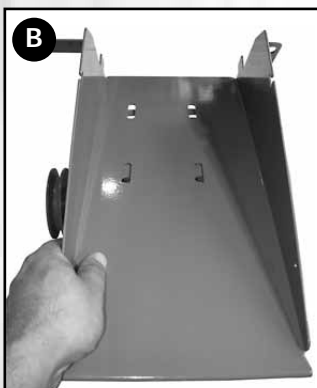


5. Attach the front top shelf K and rear top shelf L as shown in M.

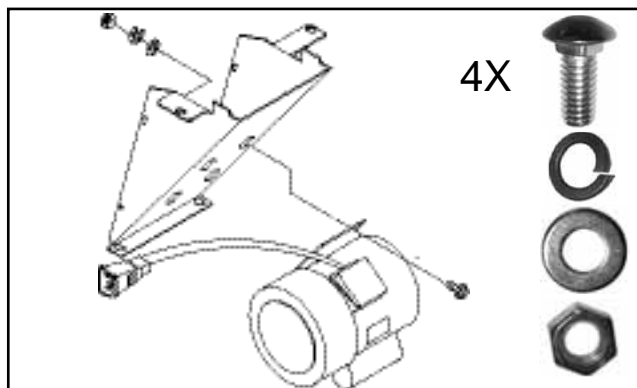


6. Attach both side top shelves N as shown in O.

### **ATTACH THE MOTOR MOUNTING BRACKET TO THE MOTOR MOUNTING PLATE- MODEL 80-075L ONLY**



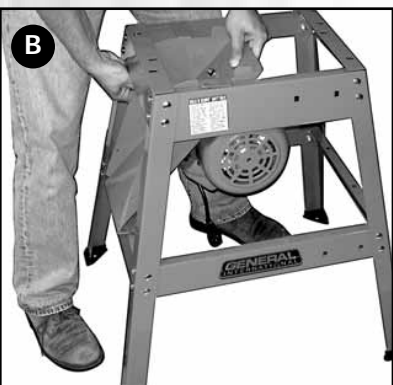
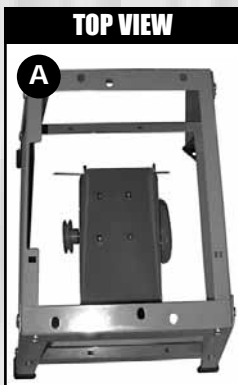
1. Lay the motor down on a bench or on the floor with the mounting plate facing up and the pulley to your left as shown in A.
2. Fit the motor mounting bracket to the motor mounting plate as shown in B.



3. Line up the holes so that they are roughly centered and secure using 4 long carriage bolts, lock washers, flat washers and hex nuts, in the assembly order shown, and tighten with the supplied 12 mm wrench.

*Note: Do not fully tighten the fasteners at this time in order to have some play left for pulley alignment later on.*

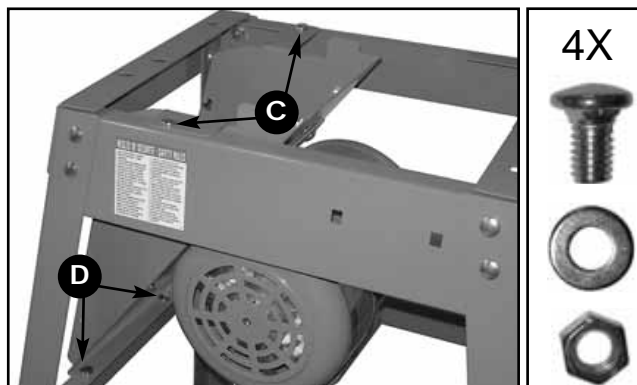
### **ATTACH THE MOTOR TO THE STAND - MODEL 80-075L ONLY**



1. Place the motor/bracket assembly on the floor with the pulley to your left, then deposit the stand roughly centered over the motor/bracket assembly as shown in A.

*Note: Make sure the motor's pulley is facing toward the rear of the stand.*

2. With the front of the stand to your right, reach in hanging the motor bracket onto the stand as shown in B.



**THE MOTOR IS HEAVY. DO NOT OVER-EXERT. THE HELP OF AN ASSISTANT WILL BE NEEDED FOR THE FOLLOWING STEP.**

3. Have an assistant attach the motor mounting bracket to the front and rear top shelves C, then left side cross brace D using 4 short carriage bolts, flat washers and hex nuts, while you are holding it in place. Fully tighten the bolts with the supplied 12 mm wrench or with a 12 mm socket wrench.

## ATTACH THE JOINTER BED TO THE **STAND (MODEL 80-075L)** / ATTACH THE JOINTER BED TO THE **BASE (MODELS 80-100L /LHC & 80-150L/LHC)**



THE JOINTER BED IS VERY HEAVY. DO NOT OVER-EXERT. THE HELP OF AN ASSISTANT WILL BE NEEDED FOR THE FOLLOWING STEP.

### Hardware Needed:

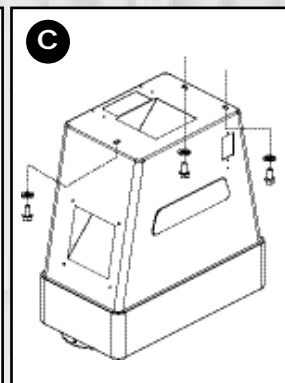
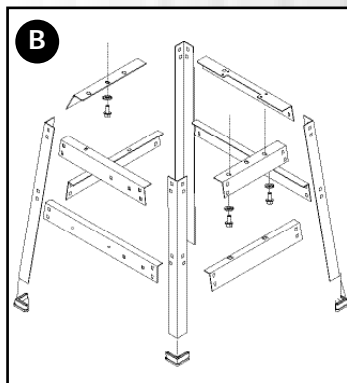
	Qty
Flange bolt	3
Large lock washer	3

3X



1. With the help of an assistant, lift the jointer bed onto the *stand* / *base*, A.
2. Align the 3 bolt holes on the jointer bed with the 3 holes on the *stand* / *base* .
3. Secure the jointer bed to the *stand* B/ *base* C, using 3 flange bolts and lock washers in the assembly order shown.

*Note: Only hand-tighten the bolts for now. Final tightening will be done after pulley alignment.*

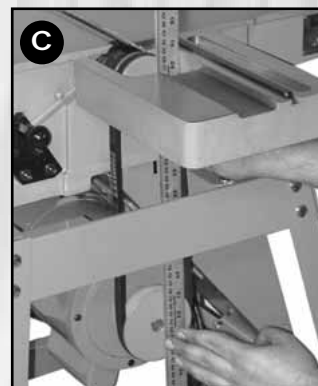
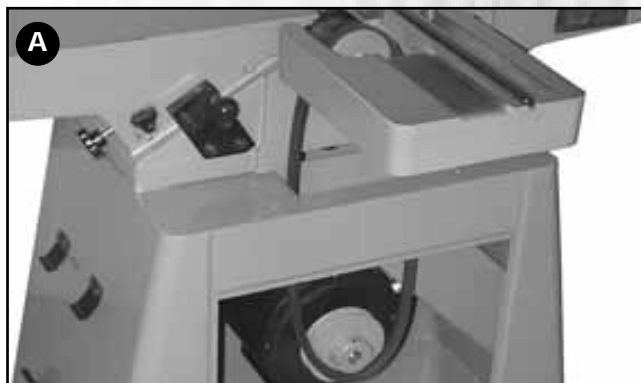


## INSTALL THE V-BELT - **ALL MODELS**

1. Install the V-belt in the groove on the upper pulley A.
2. Fit and hold a portion of the opposite end of the belt into the groove on the motor pulley.
3. Using both hands, carefully pull down on the belt to rotate the pulleys and allow the belt to seat itself in the groove B.



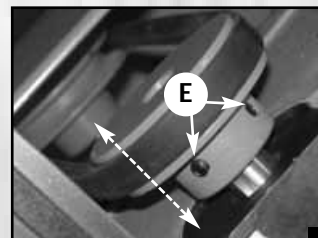
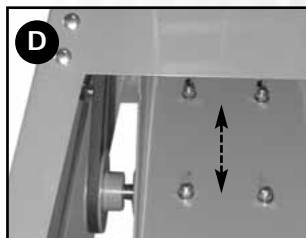
PULL SLOWLY - DO NOT USE SHARP TUGS! KEEP YOUR LOWER HAND FAR ENOUGH ABOVE THE MOTOR PULLEY TO AVOID PINCHING HAND BETWEEN THE BELT AND THE PULLEY.



## PULLEY PARALLEL ALIGNMENT - **ALL MODELS**

1. Hold a straight edge to the pulleys to check pulley alignment C.
2. Model 80-075L only
  - If the pulleys are aligned: Skip ahead to the next step.
  - If the pulleys are not aligned: Adjust the motor mounting plate D to obtain pulley parallel alignment then fully tighten the nuts with the supplied 12 mm wrench.

*Note: If pulley alignment cannot be obtained, loosen both set screws E located on the upper pulley with the supplied 3 mm Allen key and slide the pulley on its shaft to obtain parallel alignment then re-tighten the set screws.*



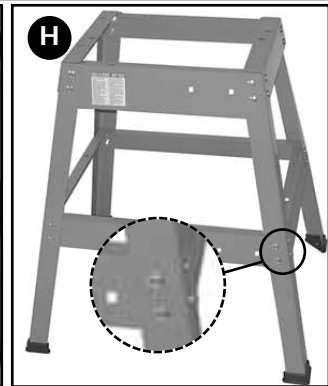
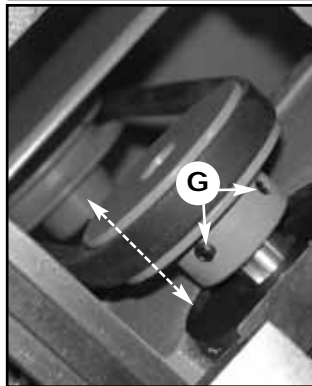
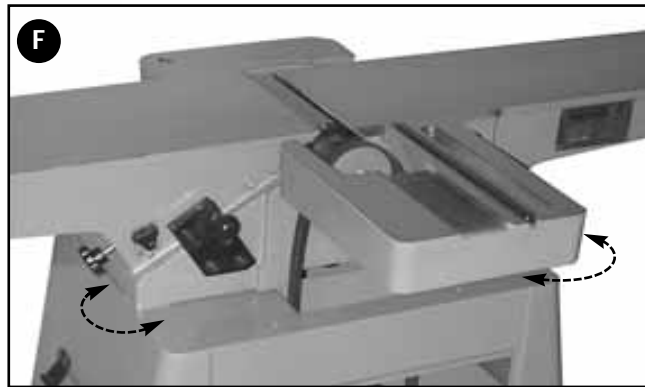
## 2. ***Models 80-100L/LHC & 80-150L/LHC only***

- If the pulleys are aligned: Fully tighten the flange bolts that secure the jointer bed to the stand with the supplied 14 mm wrench.
- If the pulleys are not aligned: Adjust the position of the jointer bed on the stand F to obtain pulley alignment then fully tighten the flange bolts that secure the jointer bed to the stand with the supplied 14 mm wrench.

**Note:** If pulley alignment cannot be obtained, loosen both set screws G located on the upper pulley with the supplied 3 mm Allen key and slide the pulley on its shaft to obtain parallel alignment then re-tighten the set screws.

## 3. ***Model 80-075L only***

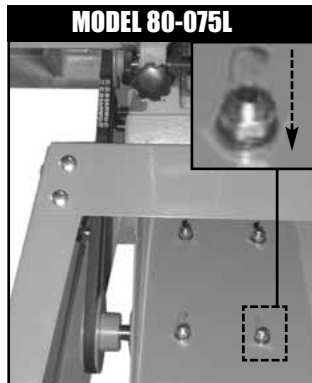
Tighten down all stand fasteners H with the supplied 12 mm wrench or with a 12 mm socket wrench.



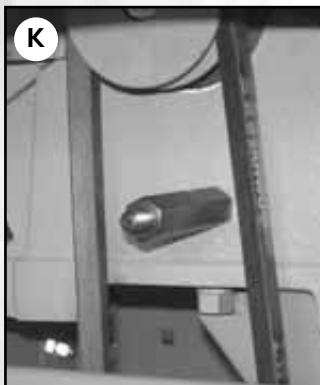
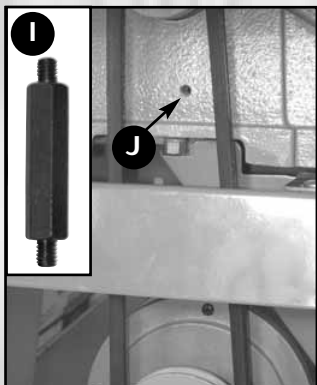
## **VERIFY BELT TENSION - ALL MODELS**

1. Push on the belt with your finger. The belt should not move more than 1/2".
2. If needed, tighten the belt by loosening the 4 motor mounting bolts and applying downward pressure on the motor then re-tighten the bolts.

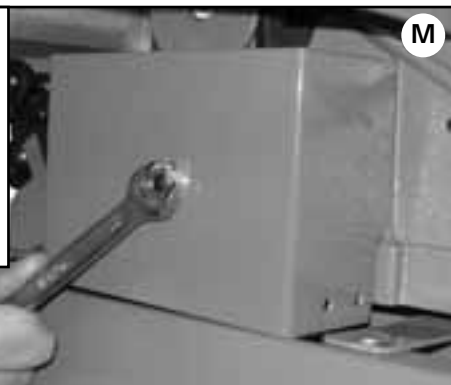
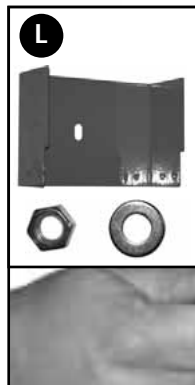
**Note:** When tightening the belt, take care not to undo pulley parallel alignment. After re-tightening the bolts, verify pulley alignment and re-adjust if needed.



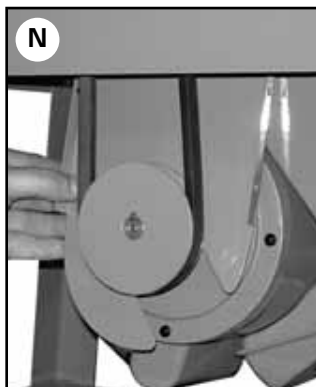
## **INSTALL THE PULLEY GUARDS - MODEL 80-075L ONLY**



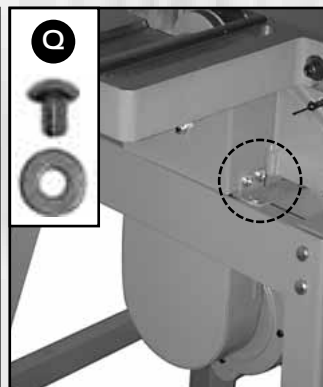
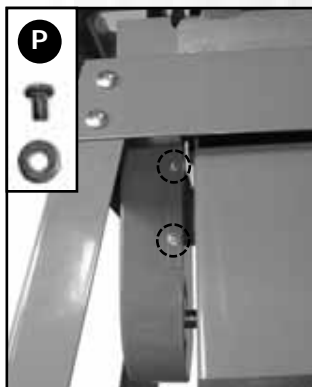
1. Thread the pulley guard stud I in the threaded hole under the upper pulley J, as shown, K.



2. Fit the upper pulley guard L on the pulley guard stud, then attach a flat washer (with large hole) and hex nut and tighten with the supplied 12 mm wrench M.

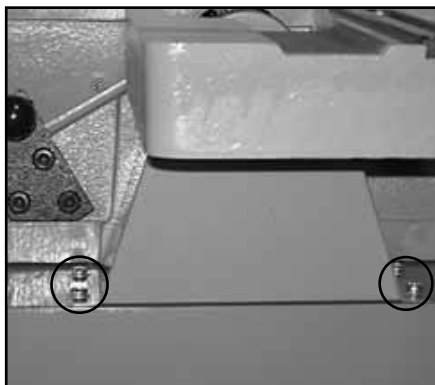


3. Place the lower pulley guard backing plate as shown, N, then fit the lower pulley guard cover over pulley and backing plate, O.



4. Attach the lower pulley guard cover to the backing plate using 4 small Phillips screws and small flat washers P (two on each side).
5. Attach the lower pulley guard to the upper pulley guard using 4 pan head Phillips screws and flat washers (with small hole) Q, (two on each side).

**INSTALL THE PULLEY GUARD - MODELS 80-100L/LHC & 80-150L/LHC ONLY**



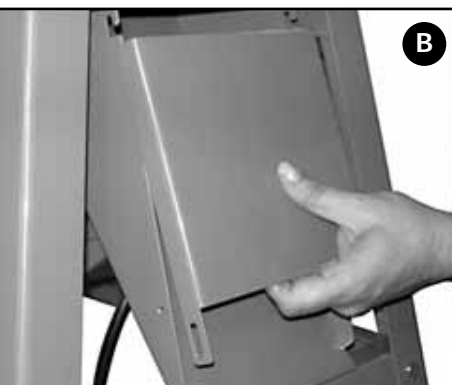
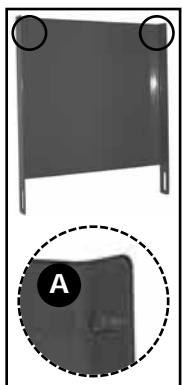
Attach the pulley guard to the top of the base using 4 small Phillips screws with small flat washers as shown.

**INSTALL THE DUST PORT - MODELS 80-100L/LHC & 80-150L/LHC ONLY**



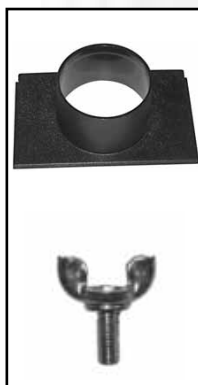
Attach the dust port to the right side of the base using small Phillips screws with small flat washers as shown.

**INSTALL THE DUST PORT MOUNTING BRACKET - MODEL 80-075L ONLY**



Hang the dust port mounting bracket to the motor mounting bracket by its two pins A as shown, B.

**INSTALL THE DUST PORT - MODEL 80-075L ONLY**



Attach the dust port to its mounting bracket using 2 wing screws, as shown.

#### **ATTACH THE SWITCH TO THE STAND - MODEL 80-075L ONLY**



Attach the switch to the stand using 4 short carriage bolts, flat washers and hex nuts, as shown.

#### **CONNECT THE SWITCH TO THE MOTOR - MODEL 80-075L ONLY**

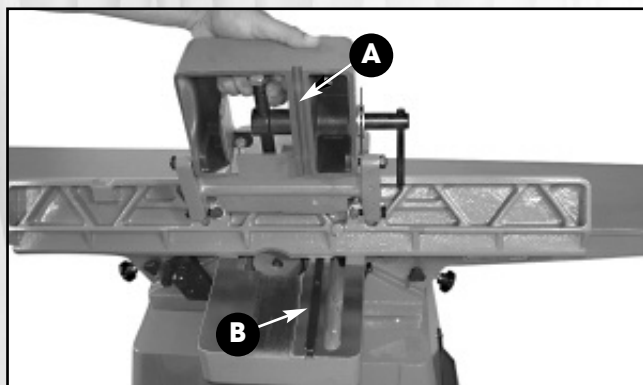


Connect the power cord from the motor to the inlet plug on the switch.

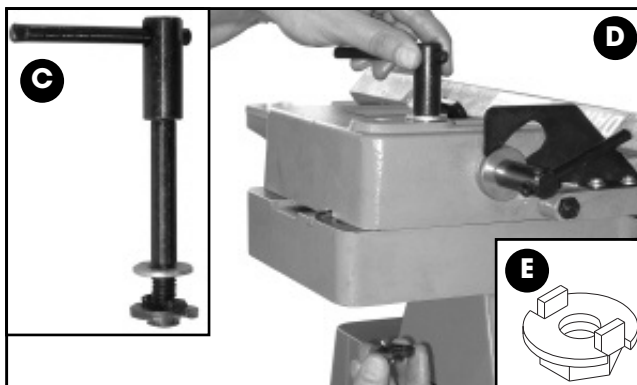


**SERIOUS PERSONAL INJURY COULD OCCUR IF YOU CONNECT THE MACHINE TO THE POWER SOURCE BEFORE YOU HAVE COMPLETED THE INSTALLATION AND ASSEMBLY STEPS. DO NOT CONNECT THE MACHINE TO THE POWER SOURCE UNTIL INSTRUCTED TO DO SO.**

#### **INSTALL THE FENCE & FENCE LOCKING HANDLE - ALL MODELS**



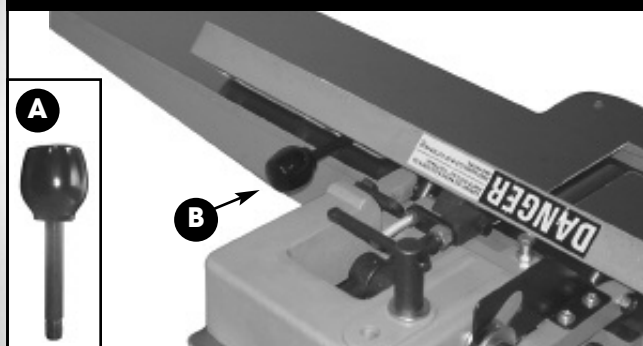
1. Install the fence on the jointer by sliding the T-slot **A** under the fence on the guide bar **B**.



2. Install the fence locking handle **C** as shown in **D**, with the lock nut oriented as shown in **E**.

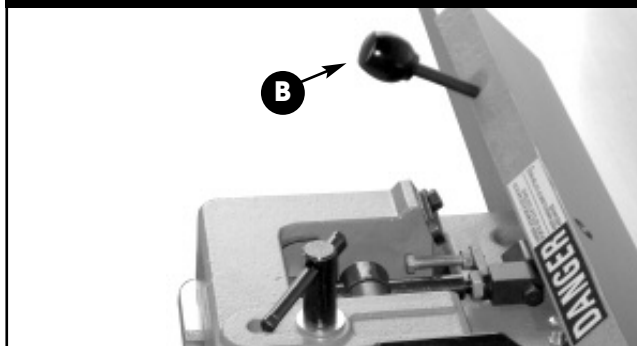
#### **INSTALL THE FENCE TILT LEVER - ALL MODELS**

##### **MODEL 80-075L**



1. Thread the knob on the fence tilt lever **A**.

##### **MODELS 80-100L/LHC & 80-150L/LHC**



2. Screw the fence tilt lever into the threaded hole in the fence **B**.

### INSTALL THE CUTTER HEAD GUARD - ALL MODELS

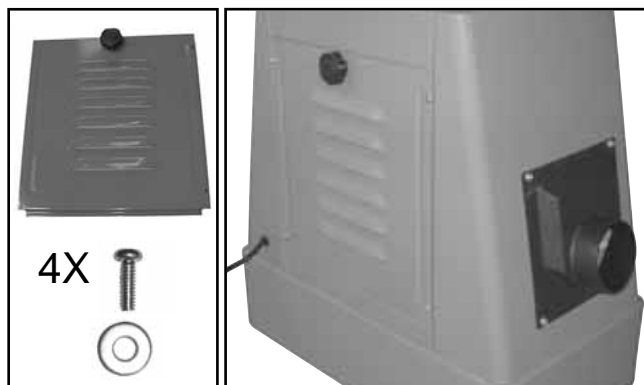
Tension is maintained on the cutter head guard using a spring loaded knob on the underside of the rabbeting arm. The tension causes the guard to automatically snap back against the fence and cover the knives once the workpiece has cleared the guard.

To install the guard:

1. Remove the set screw **A** on the guard shaft **B**.
2. Turn and hold the tension adjustment knob and fit the shaft as far as it will go down into the mounting hole on the rabbeting arm at the front of the jointer **C**.
3. To test the tension, pull back on the guard bringing it away from the table and release.
4. If you find the tension on the guard does not snap the guard back firmly enough, hold the tension adjustment knob and remove the guard.
5. Turn the tension adjustment knob another 1/2 turn and re-install the guard.
6. Test the tension again and repeat steps 4 and 5 until adequate tension is achieved.
7. To secure the guard in place, tighten the stop-screw on the bottom of the shaft **D**.

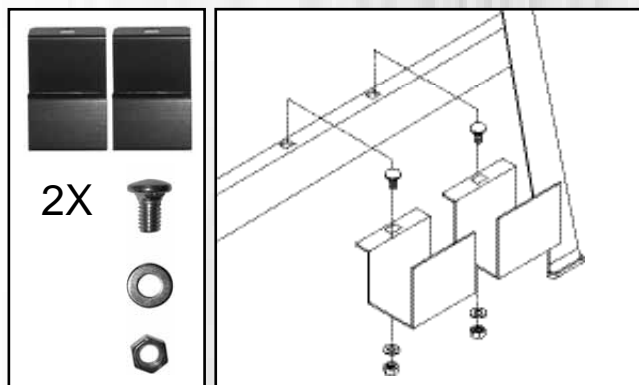


### INSTALL BASE DOOR - MODELS 80-100L & 80-150L ONLY



Attach the base door to the base using 4 x mm Phillips screws and flat washers.

### INSTALL PUSH-BLOCK STORAGE BRACKETS - MODEL 80-075L ONLY

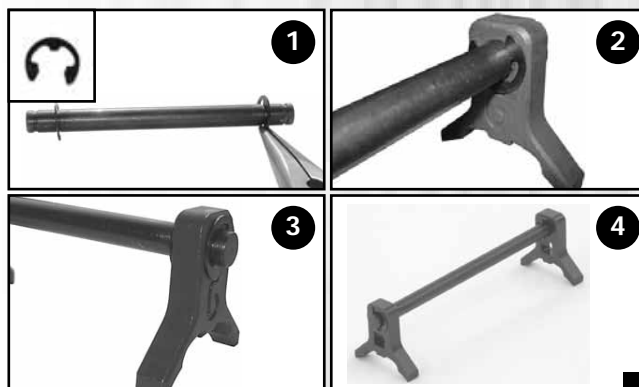


Install the push-block storage brackets on the stand right cross brace using two short carriage bolts, flat washers and hex nuts.

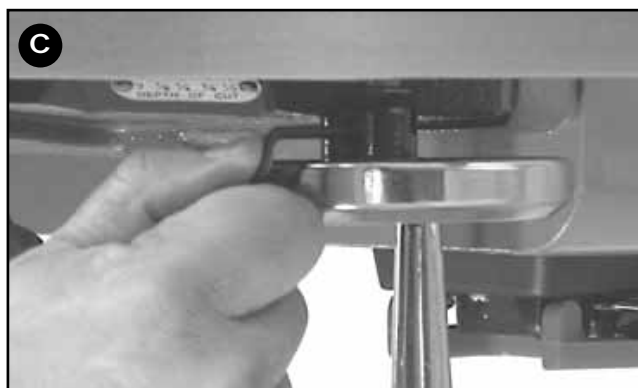
### ASSEMBLE THE KNIFE SETTING GAUGE

*Note: Models 80-075L, 80-100L and 80-150L only. This gauge is not required on models 80-100LHC and 80-150LHC due to their helical cutter head design.*

1. Using a pair of pliers, push a c-clip into the inner grooves on each end of the knife setting gauge rod.
2. Slide one foot onto one end of the rod.
3. Secure the foot on the rod by pushing a c-clip into the exposed groove in the rod.
4. Repeat step 2 and 3 to install the other foot.
5. Set the gauge aside for use whenever knife settings need to be verified or adjusted.



### **INSTALL THE TABLE HEIGHT ADJUSTMENT HANDWHEELS - MODELS 80-075L & 80-100L/LHC ONLY**

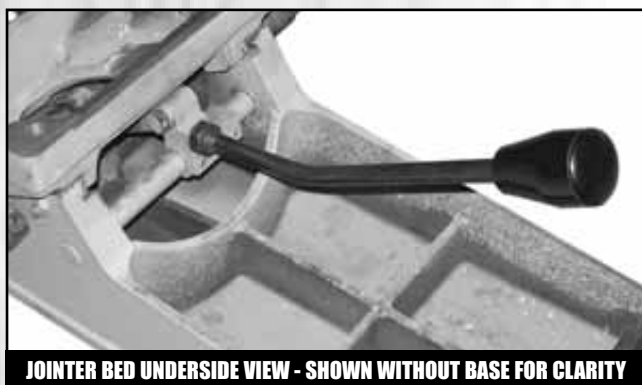


1. Fit the two table height adjustment handwheels **A** on the shafts at the front of the machine. The slots in the handwheel must be aligned with the spring pin on the shaft, **B**.
2. Using the supplied 3 mm Allen key, tighten the set screw on the shaft to secure the handwheels to the shaft, **C**.

### **INSTALL THE TABLE HEIGHT ADJUSTMENT HANDWHEEL AND LEVER - MODEL 80-150L/LHC ONLY**



1. Unscrew and remove the screw **A** on the shaft under the jointer bed.
2. Fit the out-feed height adjustment handwheel on the shaft and secure it in place using the screw you just removed.



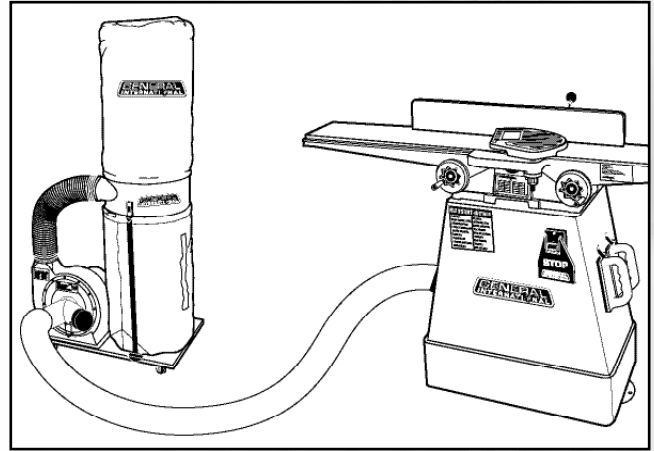
3. Screw the in-feed table height adjustment lever into the threaded hole under the jointer bed and tighten the nut.

## CONNECTING TO A DUST COLLECTOR

A dust port with a 4" opening is provided to accommodate connection to a dust collector (not included).

Once the dust port has been installed, be sure to use appropriate sized hose and fittings (not included) and check that all connections are sealed tightly to help minimize airborne dust.

If you do not already own a dust collection system consider contacting your General® International distributor for information on our complete line of dust collection systems and accessories or visit our Web Site at [www.general.ca](http://www.general.ca).



## ADJUSTING AND SETTING THE OUT-FEED TABLE HEIGHT

The out-feed table should be set level with the highest point of the knives **A**. The height of the out-feed table should be verified and adjusted prior to first use. It should also be verified and re-adjusted periodically to compensate for knife wear and also upon knife replacement.



**ALWAYS DISCONNECT THE MACHINE FROM THE POWER SOURCE BEFORE MAKING ANY ADJUSTMENTS. FAILURE TO HEED THIS WARNING CAN LEAD TO SERIOUS PERSONAL INJURY.**

1. Make sure that the machine is disconnected from the power source.
2. To give yourself unimpeded access to the cutter head and upper pulley, remove the cutter head guard and fence.
3. Set a straightedge onto the out-feed table so that it sits over the cutter head but does not completely cross the gap between the tables and touch the in-feed table **A**.
4. Turn the upper pulley by hand, until any one of the knives is at it's highest point.

5. **Models 80-075L & 80-100L/LHC**

Loosen the out-feed table height adjustment hand wheel lock knob **B** then loosen the table height setting locking lever **C**.

**Models 80-150L/LHC**

Loosen the out-feed table height adjustment hand wheel locking lever **D** then loosen the table height setting locking lever **E**.

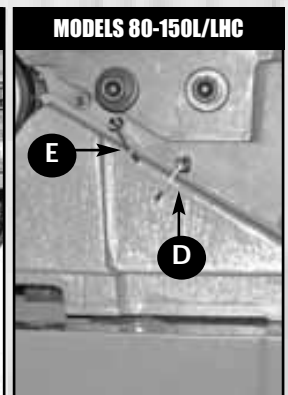
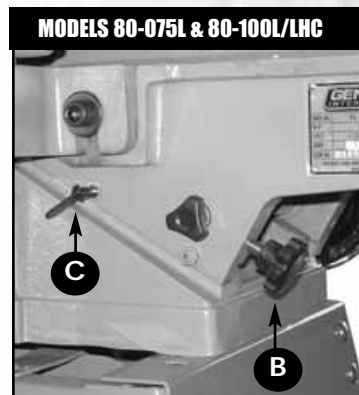
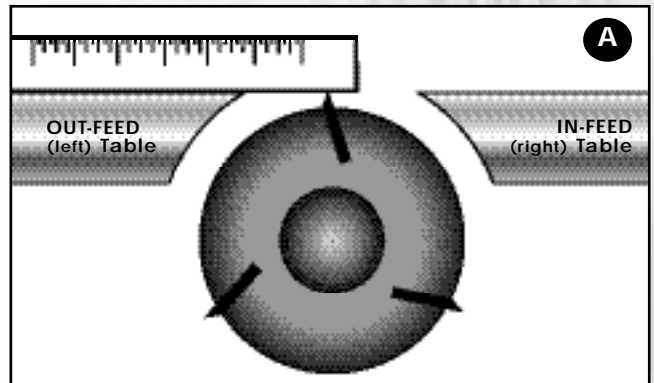
6. Use handwheel **F** to adjust the out-feed table height so that the knife **barely touches** the straightedge.

7. **Models 80-075L & 80-100L/LHC**

Re-tighten lock knob **B** and locking lever **C** to secure the out-feed table in position and lock the hand wheel.

**Models 80-150L/LHC**

Re-tighten locking levers **D** and **C** to secure the out-feed table in position and lock the handwheel.



# ADJUSTING AND SETTING THE IN-FEED TABLE HEIGHT / DEPTH OF CUT

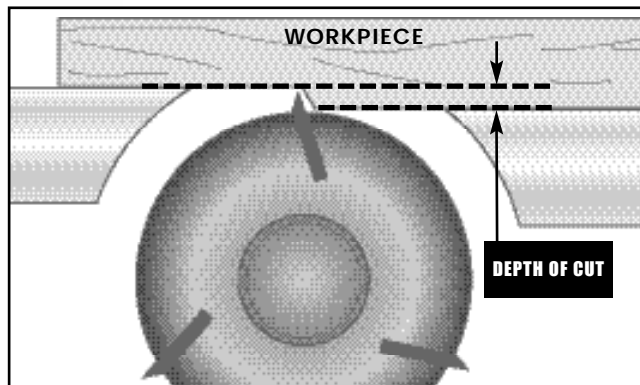
The depth of cut is set by raising or lowering the in-feed table.

Refer to the recommended depth of cut settings in section "Basic Jointing Operations Instructions", on page 25.

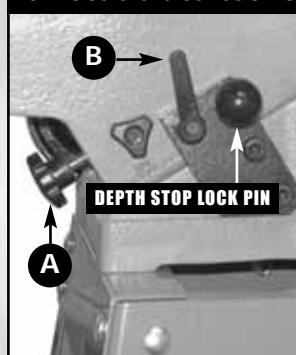


THE MAXIMUM DEPTH OF CUT FOR ONE PASS IS 1/8". NEVER ATTEMPT TO REMOVE MORE MATERIAL THAN 1/8" IN ANY SINGLE PASS.

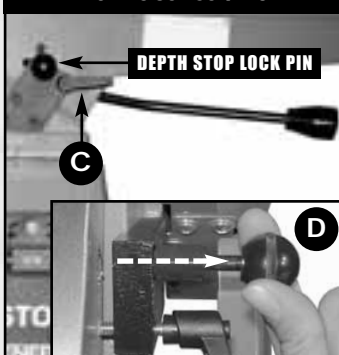
ALWAYS DISCONNECT THE MACHINE FROM THE POWER SOURCE BEFORE MAKING ANY ADJUSTMENTS. FAILURE TO HEED THIS WARNING CAN LEAD TO SERIOUS PERSONAL INJURY.



**MODELS 80-075L & 80-100L/LHC**



**MODELS 80-150L/LHC**



## 1. Models 80-075L & 80-100L/LHC

Loosen the in-feed table height adjustment hand wheel lock knob **A** then loosen the table height setting locking lever **B**.

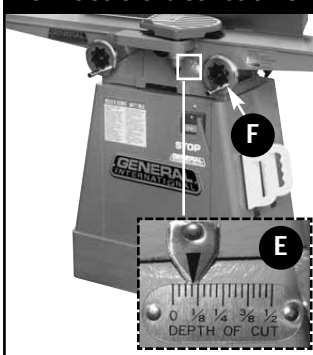
### Models 80-150L/LHC

Loosen the table height setting locking lever **C**.

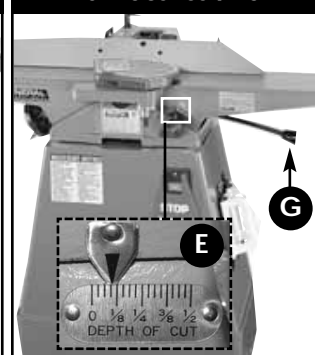
## 2. Pull & hold back the 1/8" depth stop lock-pin **D**.

**Important! Never adjust the table height with the lock-pin engaged as this will break the pin.**

**MODELS 80-075L & 80-100L/LHC**



**MODELS 80-150L/LHC**



*Note: Refer to the graduated depth scale **E**.*

## 3. Models 80-075L & 80-100L/LHC

Use handwheel **F** to adjust in-feed table height to the desired depth of cut and then release the 1/8" depth stop lock-pin and retighten lock knob **A** and locking lever **B** to secure the in-feed table in position and lock the handwheel.

### Models 80-150L/LHC

Use quick-lever **G** to adjust in-feed table height to the desired depth of cut and then release the 1/8" depth stop lock-pin and re-tighten locking lever **C** to secure the in-feed table in position.

## SETTING THE IN-FEED TABLE MIN/MAX HEIGHT - MODELS 80-150L/LHC ONLY

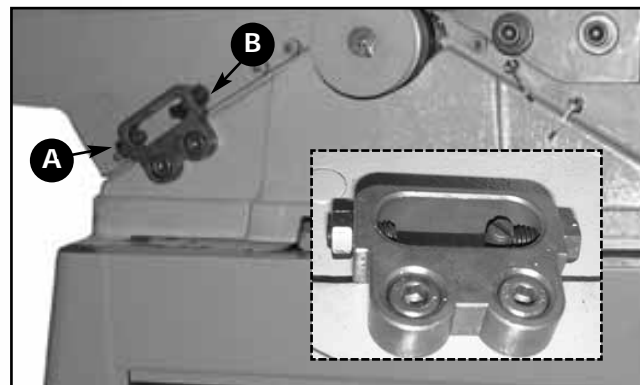
In addition to the 1/8" depth stop, 2 other depth stops can be set on models 80-150L/LHC by setting the in-feed table minimum and maximum height.

To set the table minimum height:

1. Loosen bolt **A**.
2. Adjust in-feed table to the desired minimum height then re-tighten bolt **A**.

To set the table maximum height:

1. Loosen bolt **B**.
2. Adjust in-feed table to the desired maximum height then re-tighten bolt **B**.



# ADJUSTING THE FENCE & CHECKING / SETTING THE FENCE STOPS

The fence stops allow you to position the fence at specific pre-set angles in relation to the tables without having to measure each time you return to that angle.

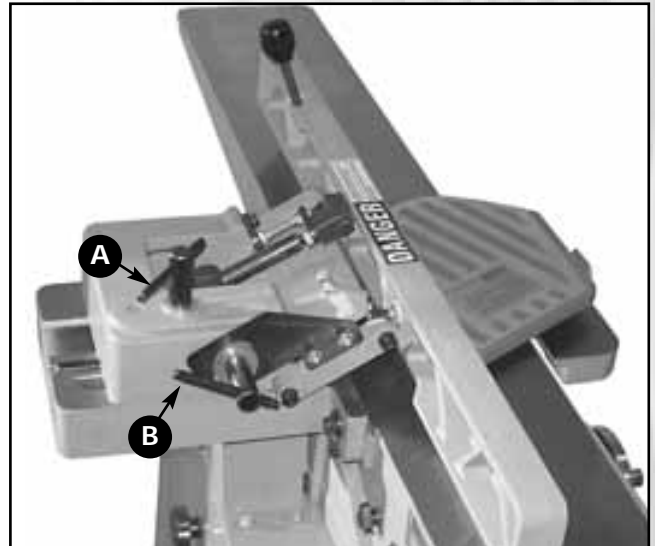
Due to wear and vibration, fence stops can over time become misaligned and should be checked periodically and re-set if necessary.

To move the fence front to back:

1. Loosen locking handle A.
2. Position the fence over the cutter head as needed.
3. Re-tighten locking handle A.

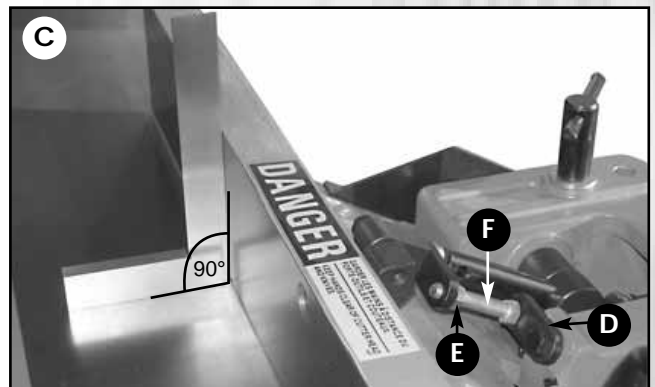
To tilt the fence:

1. Loosen locking handle B.
2. Set the fence 45° inward or 45° outward
3. Re-tighten locking handle B.



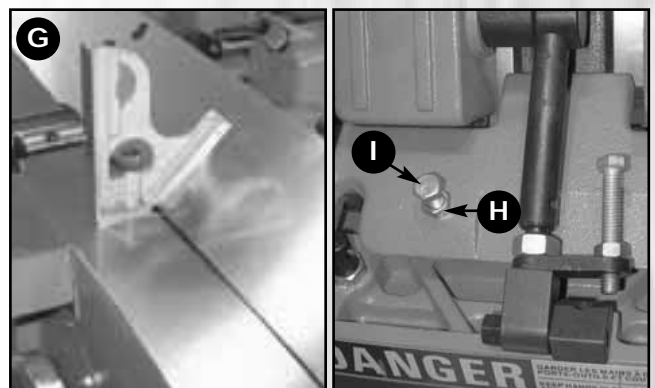
To set the 90° fence stop:

1. Using a 90° combination or machinists square, set the fence to 90° C.
2. Flip the 90° stop into position D.
3. Loosen the jam nut E on the 90° fence stop bolt.
4. Adjust the 90° fence stop bolt F until it makes contact with the 90° stop.
5. Retighten the jam nut.



To set the 45° outward fence stop:

1. Using a combination or machinists square, set the fence to 45° outward G.
2. Loosen the jam nut H on the 45° outward fence stop bolt.
3. Adjust the 45° outward fence stop bolt I until it makes contact with the back of the fence.
4. Retighten the jam nut.



To set the 45° inward fence stop:

1. Using a 45° combination or machinists square, set the fence to 45° inward J.
2. Loosen the jam nut K.
3. Adjust the 45° inward fence stop nut L until it makes contact with the 45° inward stop M.
4. Retighten the jam nut.



# CHECKING KNIVES

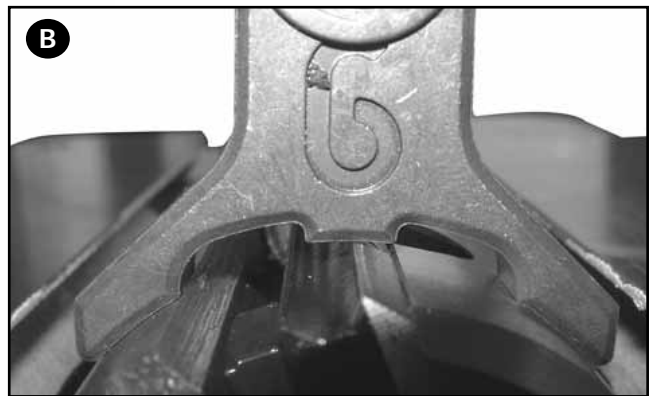
The knives have been factory set to the exact same height in the cutter head. However we suggest that you verify that the knives are properly set prior to first use.

Accurate work results can only be achieved when all three knives are properly installed and set to the exact same height in the cutter head. To verify if the knives are set properly, use the supplied knife setting gauge **A** following the steps below for each of the three knives:



**ALWAYS DISCONNECT THE MACHINE FROM THE POWER SOURCE BEFORE MAKING ANY ADJUSTMENTS. FAILURE TO HEED THIS WARNING CAN LEAD TO SERIOUS PERSONAL INJURY.**

1. Make sure that the machine is disconnected from the power source.
2. To give yourself unimpeded access to the cutter head and knives, remove the cutter guard.
3. Using the table height adjustment handwheels, lower the tables enough to allow the knife setting gauge **A** to fit fully on the cutter head.
4. Remove the fence to have access to the upper pulley and turn it by hand to rotate the cutter head.
5. Set the gauge onto the cutter head with the center reference pads of the gauge sitting directly above a knife.
6. Observe how the gauge sits on the cutter head and how/if the knife touches the center reference pads. The ideal position has both sets of feet of the gauge sitting flush on the cutter head and the knife barely touching the center reference pads on the gauge **B**.
7. Should any (or all) of the knives not be set properly, follow the instructions in section "Knife Setting or Replacement", on page 27.



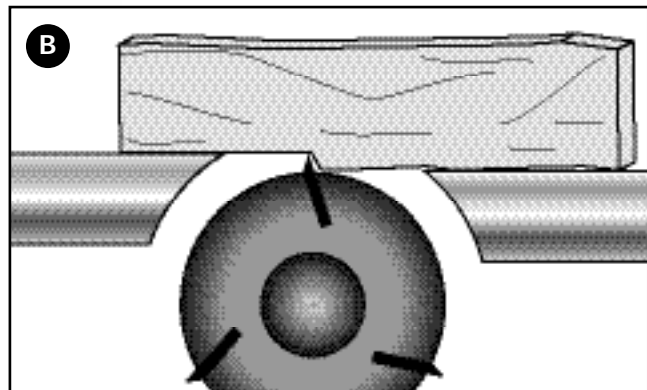
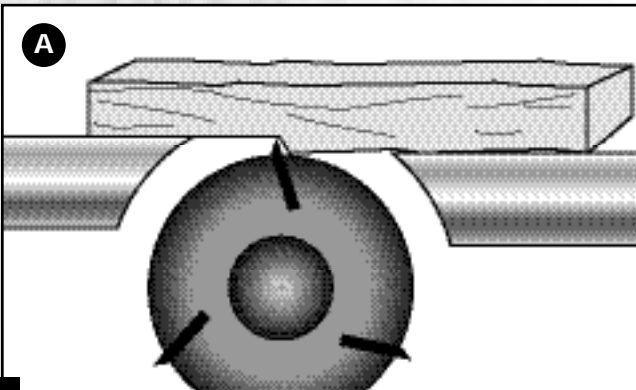
# OPERATING INSTRUCTIONS

## **BASIC PRINCIPLES OF JOINTING**

This jointer is designed to remove material from the bottom face of a board in order to bring one face of the board (or a series of boards) perfectly flat **A**.

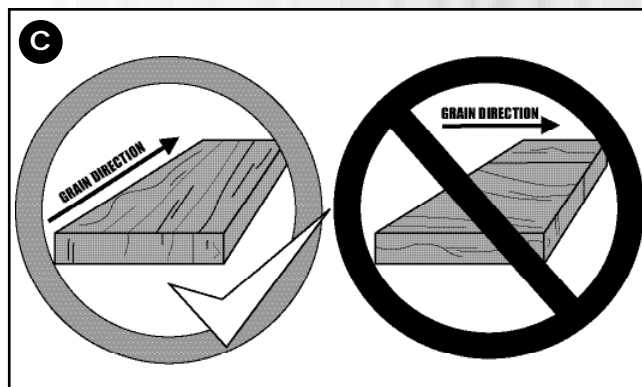
This perfectly flat face is then placed against the fence, set at 90° to the tables, to obtain a perfectly perpendicular 90° flat edge **B**.

This jointer is not intended (and should not be used) to joint any material other than solid wood.



### **SELECTING BOARDS SUITABLE FOR JOINTING**

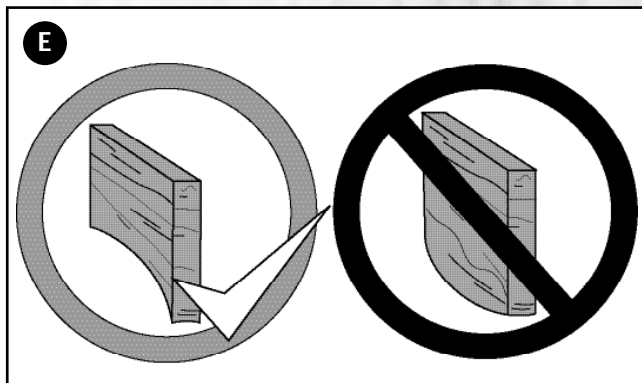
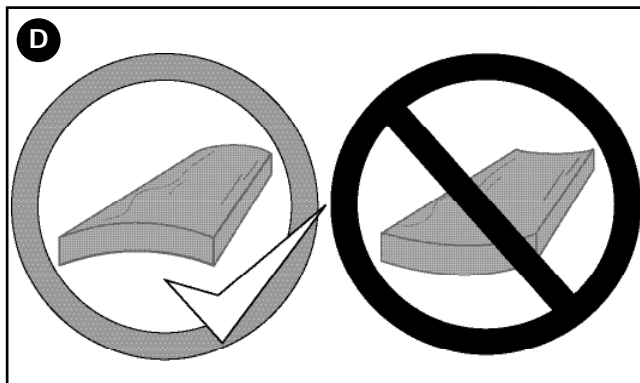
1. Jointing safety begins with the stock used with the machine. Inspect the work piece carefully before jointing it. Never joint a board that has loose knots, staples, nails or other embedded foreign objects. If you have the slightest doubt about the structural integrity or stability of a board: **Do Not Joint It.**
2. Only boards with the grain running more or less lengthwise are suitable for jointing C.



**ALWAYS JOINT IN THE GENERAL DIRECTION OF THE GRAIN. JOINTING AGAINST THE GRAIN OR JOINTING END GRAIN IS DANGEROUS AND MAY CAUSE THE WORKPIECE TO SHATTER.**

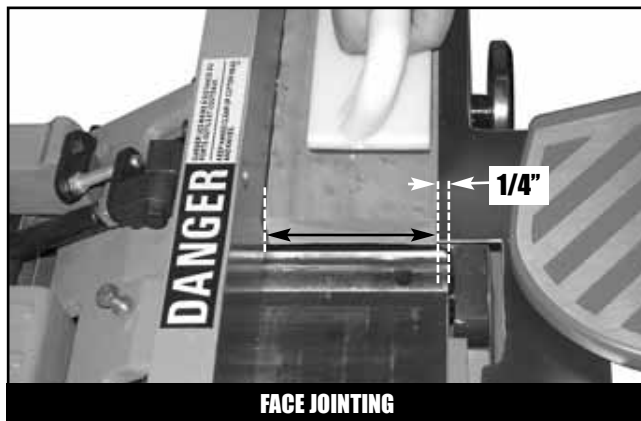
### **DETERMINE THE CONCAVE FACE AND EDGE OF YOUR BOARD**

Place your board on a flat surface to identify its concave face D and edge E. The boards must be jointed with its concave face and edge against the jointer table.

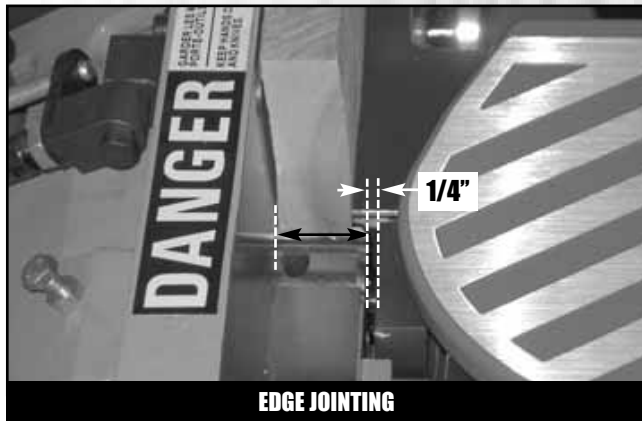


### **ADJUST FENCE FRONT TO BACK POSITION**

To limit your exposure to the knives in the cutter head, never take more knife length than is required to complete the cut. Set the position of the fence so that the length of blade remaining exposed is roughly 1/4" longer than the width of the board to be jointed.



**FACE JOINTING**



**EDGE JOINTING**

## CHECKLIST BEFORE STARTING



VERIFY ALL CHECK POINTS BEFORE STARTING. FAILURE TO COMPLY CAN RESULT IN SERIOUS INJURIES.

- Make sure you and any assistants are wearing safe appropriate workshop attire. Roll up long sleeves, secure long hair and remove any jewelry: watches, rings, bracelets or anything that could become caught in the moving parts, potentially causing serious injury.
- Make sure the board has been inspected and is suitable for jointing as explained in the previous section "Selecting boards suitable for jointing".
- Verify that the cutter head guard is functioning properly (snaps back against the fence and covers the knives).
- Make sure that the fence is properly set and locked in place.
- Make sure to have on safety glasses as well as hearing and respiratory protection at all times when using the jointer.

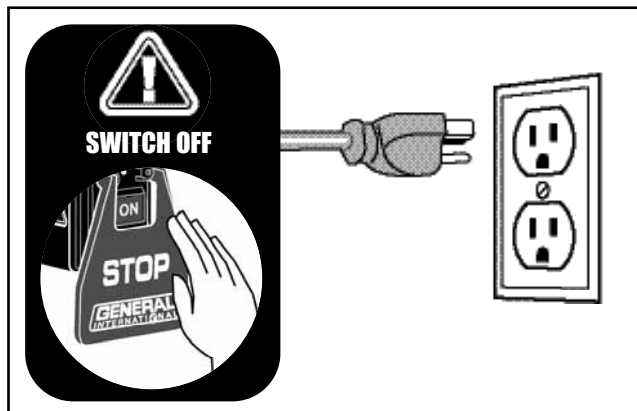
## CONNECTING TO A POWER SOURCE



TO REDUCE THE RISK OF SHOCK OR FIRE DO NOT OPERATE THE UNIT WITH A DAMAGED POWER CORD OR PLUG. REPLACE DAMAGED CORD OR PLUG IMMEDIATELY.

TO AVOID UNEXPECTED OR UNINTENTIONAL START-UP, MAKE SURE THAT THE POWER SWITCH IS IN THE OFF POSITION BEFORE CONNECTING TO A POWER SOURCE.

Once the assembly and adjustment steps have been completed, uncoil the power cord and plug it into an appropriate outlet. Refer back to the section entitled "ELECTRICAL REQUIREMENTS" and make sure all requirements and grounding instructions are followed. When jointing operations have been completed unplug the jointer from the power source.



## ON/OFF SWITCH & SAFETY PIN

The ON/OFF switch assembly A is equipped with a lock-out safety pin B. When the pin is installed through the green "ON" button C, the machine cannot be started.

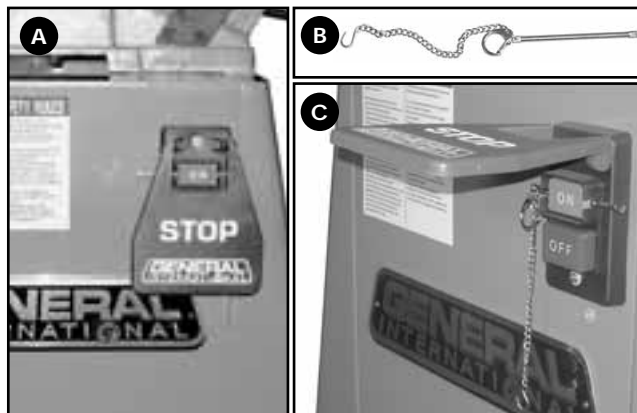
### To start the machine

Lift the red stop switch panel and remove the lock-out pin. Lower the stop panel and push the green "ON" button. Wait for the cutter head to reach full speed before jointing.

### To stop the machine

Push on the RED "STOP" panel and wait for the cutter head to come to a complete stop.

When you have finished using the machine be sure to re-install the lock-out pin and unplug the jointer from the power source.



# BASIC JOINTING OPERATIONS

## **SURFACE PLANING**

1. Inspect the stock before starting & remove any foreign objects or debris.
2. Set the depth of cut as required (1/32" is recommended for face planing - Less for hard wood or wider stock.)
3. Set & lock the fence at 90°.
4. If your workpiece is cupped, place the cupped side face down on the infeed (right) table.
5. Set the position of the fence so that the length of blade remaining exposed is roughly 1/4" longer than the width of the board to be jointed.
6. Turn on the machine & using push blocks press the stock against the table and tight to the fence, feeding the stock over the cutter head.
7. Inspect the board & repeat the steps if needed until the surface is flat.



FAILURE TO USE PUSH BLOCKS WHEN SURFACE PLANING MAY RESULT IN SERIOUS PERSONAL INJURY. ALWAYS USE PUSH BLOCKS TO HELP KEEP YOUR HANDS AT A SAFE DISTANCE FROM THE KNIVES WHEN SURFACE PLANING.

## **EDGE JOINTING**

1. Inspect the stock before starting & remove any foreign objects or debris.
2. Set the depth of cut as required (1/16" - 1/8" is recommended for edge jointing - Less for hard wood or wider stock.)
3. Set & lock the fence at 90°
4. If your workpiece is cupped, place the cupped side face down on the infeed (right) table.
5. Set the position of the fence so that the length of blade remaining exposed is roughly 1/4" longer than the width of the board to be jointed.
6. Turn on the machine, press the stock against the table and tight to the fence, feeding the stock over the cutter head.
7. Inspect the board & repeat the steps if needed until the surface is flat.



## **RABBETING**

1. Remove the cutter guard & move the fence forward leaving only the width of the desired rabbet on the tables uncovered by the fence & lock the fence in position.



REMOVE THE CUTTER GUARD FOR RABBETING ONLY. IMMEDIATELY REPLACE THE CUTTER GUARD WHEN FINISHED. DO NOT PERFORM ANY OTHER JOINTING OPERATION WITH THE CUTTER GUARD REMOVED. FAILURE TO HEED THIS WARNING CAN LEAD TO SERIOUS PERSONAL INJURY.

2. Inspect the stock before starting & remove any foreign objects or debris.
3. Set the depth of cut as required (1/16" - 1/8" is recommended for rabbeting - Less for hard wood or wider stock.)
4. Turn on the machine & using push blocks press the stock against the tables rabbeting arm and tight to the fence, feeding the stock over the cutter head.
5. Repeat the steps until the rabbet is cut to desired depth.

# MAINTENANCE



**MAKE SURE THE JOINTER HAS BEEN TURNED OFF AND UNPLUGGED FROM THE POWER SOURCE BEFORE PERFORMING ANY MAINTENANCE. FAILURE TO HEED THIS WARNING CAN LEAD TO SERIOUS PERSONAL INJURY.**

## INSPECTING/REPLACING CUTTER HEAD KNIVES

### Models 80-075L, 80-100L & 80-150L only:

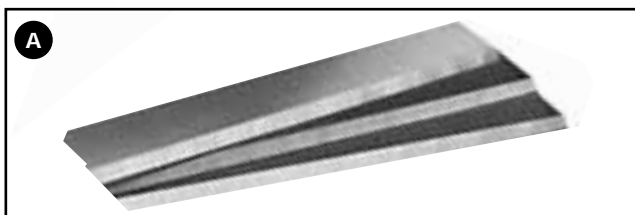
There are 3 knives installed in the cutter head at the factory. With usage and normal wear over time, it will eventually become necessary to replace the knives. To maintain even knife wear always replace all 3 knives at the same time.

When needed, replacement knives (sold in sets of 3) **A** can be ordered through your local General International distributor under part #80-105 (High Speed Steel) or #80-110 (Carbide).

### Models 80-100LHC & 80-150LHC only:

There are 16 reversible carbide inserts (knives) installed in the helical cutter head at the factory. With usage and normal wear over time, it will eventually become necessary to reverse and/or replace the inserts. To maintain even insert wear always reverse or replace all 16 inserts each time knife replacement is required.

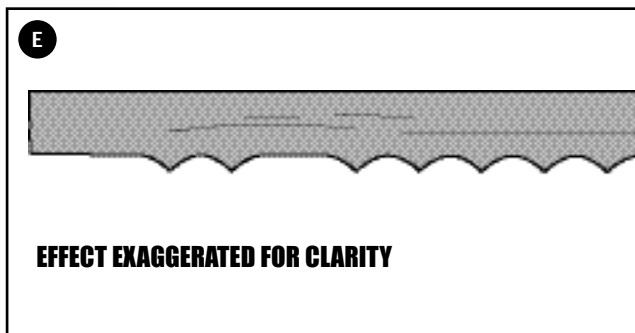
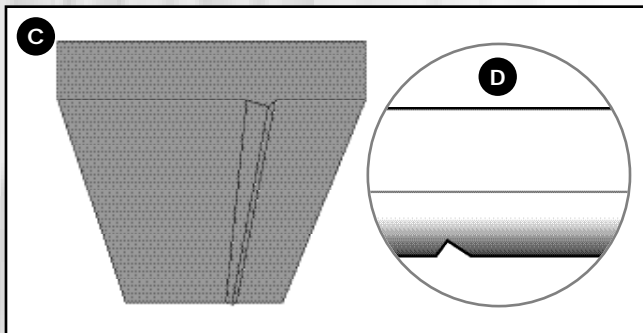
When needed, replacement inserts **B** can be ordered through your local General International distributor under part #30-443.



### ALL Models:

Observing jointed workpieces as they come off of the machine and looking for signs of knife damage or wear is the best method to help you to determine when knives are due to be changed.

Signs to look for include:



1. A raised ridgeline in the workpiece that runs a straight line from beginning to end of the board **C**. This is generally an indication that one or more knives has been nicked or damaged **D** by a foreign object such as a nail, staple or other hard object hidden or embedded in the workpiece.
2. A slight washboard or chatter effect **E** which can be an indication of uneven knife wear causing one knife to cut slightly deeper than the others.
3. Rough, irregular, torn or fuzzy grain on a freshly jointed surface may be a sign of worn or dull blades causing the wood to tear out. Sharp blades cut crisply and leave a relatively smooth finish.

**Note:** Fuzzy grain can also be a sign of high moisture content in the workpiece. If knives have recently been changed or if you suspect that moisture content and not dull knives is the cause, set the workpiece aside and test by jointing other boards with known or acceptable moisture content. If the jointed results using a different workpiece are smooth, then moisture content in your wood is the problem - no adjustments can be made to the machine for this. Set the "wet" stock aside and simply work with drier wood.

## KNIFE SETTING OR REPLACEMENT - MODELS 80-075L - 80-100L & 80-150L ONLY

Properly setting all three knives is essential to achieving accurate work results. Properly set knives will last longer and also keep their edge (sharpness) longer by equally sharing the cutting workload. You may use the supplied knife setting gauge to help you set the knives to the correct height whenever re-setting or changing knives.

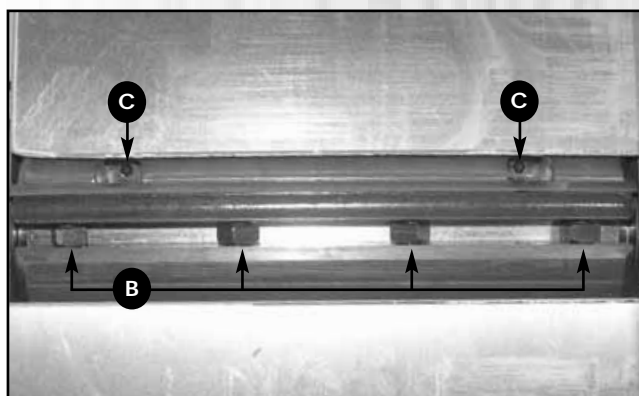
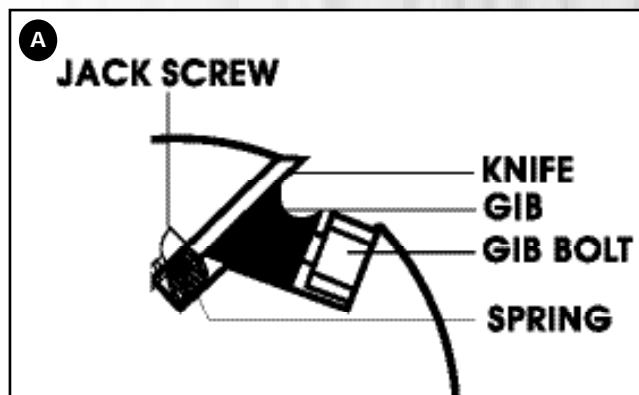
**Note:** If you prefer you may also find other “aftermarket” gauges, jigs or knife setting tools that are to your liking – ask your local tool distributor for information on any such tools that may be available in your market.

The cutter head on this unit is supplied with both adjustment springs and jack screws **A** providing you with two options for setting the knives. We suggest you try each method at least once or twice and decide for yourself which method works best and fastest for you.



**KNIVES ARE VERY SHARP. USE CARE WHEN HANDLING KNIVES.**

1. Turn off and disconnect the machine from the power source.
2. To give yourself unimpeded access to the cutter head and knives, remove the cutter guard and lower the tables as far as they go.
3. Remove the fence to have access to the upper pulley and turn it by hand to rotate the cutter head to access one of the knives.
4. Loosen (but don't remove) all the gib bolts **B** – start in the center and alternate sides (If replacing an old or damaged knife, loosen the bolts until the knife can be removed and install a new sharpened knife). Then position the gauge over the selected knife **D**.
5.
  - a) To use the adjustment springs to set the knife height: Push the knife down with the gauge so that the edge of the knife is touching the center reference pads on the gauge **E**. Hold the gauge down and tighten the bolts **B** to secure the knife in place. Repeat for the 2 other knives.
  - b) To use the Jack Screws to set the knife height: Use an Allen key to turn the screws **C** to raise or lower the knife as needed until the ideal position - both sets of feet of the gauge sitting flush on the cutter head and the knife barely touching the center reference pads on the gauge **E** - has been achieved. Repeat for the 2 other knives.
6. Re-check the height setting on all the knives and re-set if necessary.
7. Reset the tables and replace the fence and blade guard.

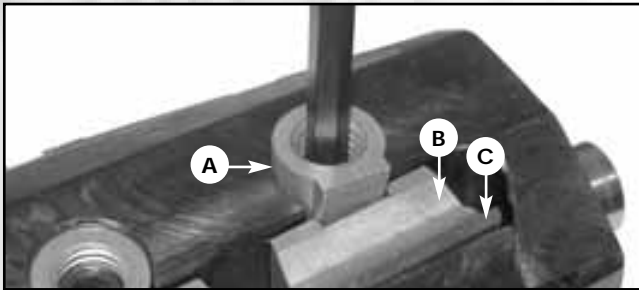


**IMPORTANT!** After changing or resetting the knives, the out-feed (left) table height must be re-adjusted to match the new height of the knives. Follow the instructions in section “Adjusting and Setting the Out-Feed Table Height” on page 19.

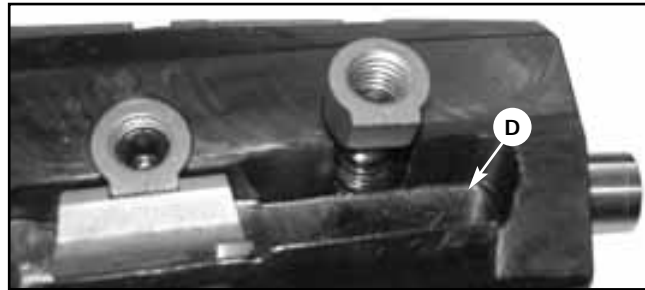
## HELICAL CUTTER HEAD INSERT REVERSAL / REPLACEMENT - *MODELS 80-100LHC & 80-150LHC ONLY*



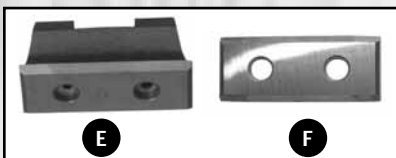
INSERT EDGES ARE VERY SHARP. USE CARE WHEN HANDLING INSERTS.



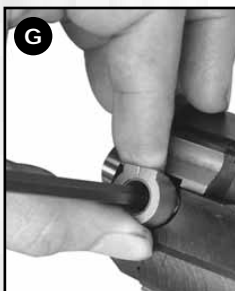
1. Using the one of the two supplied Allen keys, loosen but do not remove the nut and screw A and remove the knife-holder/chip breaker B and insert C.



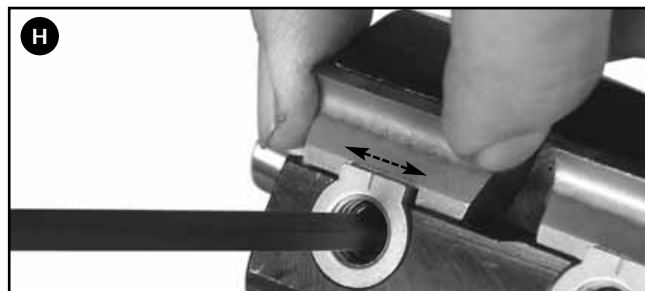
2. Thoroughly clean the housing D before reinstalling a knife-holder/chip breaker and insert.



**Important!** To prevent knife height discrepancies, the knife holders / chip breakers and inserts must be clean and free of debris.



3. Thoroughly clean the knife-holders/chip breakers E and inserts F using a lacquer thinner and small brush.
4. Reverse or replace the insert and re-install it along with the knife-holder/chip breaker into the slot, then partially retighten the nut and screw G.



5. Center the knife-holder/chip breaker with the flat edge of the nut H and fully tighten the nut and screw.
6. Repeat with all other inserts.

**Important!** The nut and screw that secures the knife-holder/chip breakers and inserts in the cutter head does not have to be removed for blade reversal/replacement, only loosened. If the nuts and screws have to be replaced or if they have been removed instead of loosened, follow the instructions below to make sure that the knife-holder/chip breakers are all secured at the same height into the cutter head.



1. Place the screw in the threaded hole but don't start tightening it yet.



2. Place the nut on top of the screw but don't start tightening the screw yet.



3. Holding the nut with your fingers, tighten the screw. This will tighten both the screw and nut simultaneously.



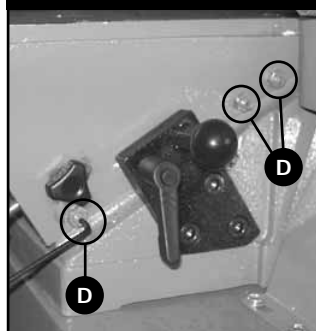
**Do not thread the nut onto the screw before tightening the screw into the threaded hole in the cutter head.**

## ADJUSTING THE GIBS

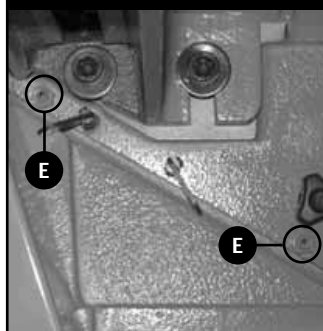
The table gibs allow you to eliminate excessive play when raising/lowering the tables and, when properly adjusted, will allow for a smoother and easier table height adjustment.

1. Loosen the three gib nuts at the back of the in-feed table **D**.
2. Tighten all three gib set screws an equal amount then test raising/lowering the table. Continue to adjust the set screws as needed until you find the right balance between easy movement and minimal play.
3. Repeat these steps for the out-feed table gib nuts **E**, then verify and adjust (if necessary) the out-feed table height following the instructions in section "Adjusting and Setting the Out-Feed Table Height" on page 19.

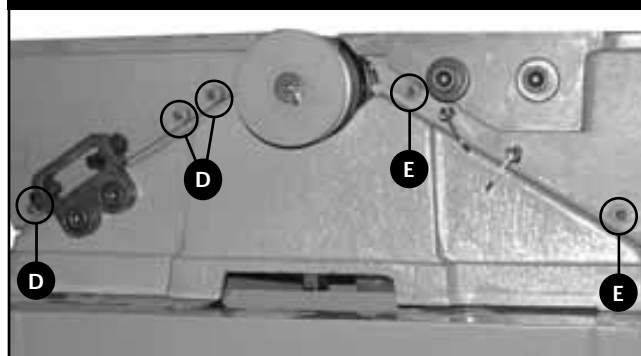
**MODELS 80-075L & 80-100L/LHC  
IN-FEED TABLE**



**MODELS 80-075L & 80-100L/LHC  
OUT-FEED TABLE**



**MODELS 80-150L/LHC**



## PERIODIC MAINTENANCE

To prolong the service life of your jointer and to maintain optimum performance the following basic maintenance procedures should be practiced and become part of your shop routine.

- Inspect/test the ON/OFF switch before each use. Do not operate the jointer with a damaged switch; replace a damaged switch immediately.
- Keep the machine as well as the in-feed out-feed tables clean and free of saw dust, woodchips, pitch or glue. Vacuum or brush off any loose debris and wipe down the machine and the tables occasionally with a damp rag.
- An occasional light coating of paste wax can help protect the tables' surface and reduce workpiece friction. Ask your local distributor for suggestions on aftermarket surface cleaners, protectant and dry lubricants based on what is readily available in your area.
- Avoid using silicon based products that may affect or react with wood finishing products such as oil, solvent or water-based stains, varnishes and lacquers.
- Periodically inspect the power cord and plug for damage. To minimize the risk of electric shock or fire, never operate the planer with a damaged power cord or plug. Replace a damaged power cord or plug at the first visible signs of damage.
- All bearings are sealed and permanently lubricated and no further lubrication is required. The fence assembly and table ways also should not be lubricated. If you should encounter a "sticking" problem, simply disassemble and clear away any obstructions from the ways.
- Regularly inspect jointed workpieces for signs of knife damage or wear and replace damaged or worn knives immediately.
- Inspect the belt regularly – To avoid potentially costly downtime, consider keeping a spare replacement belt on hand for use if needed. Belts that show visible signs of wear such as cracks or fraying at the edges should be replaced immediately.

# RECOMMENDED OPTIONAL ACCESSORIES

We offer a large variety of products to help you increase convenience, productivity, accuracy and safety when using your jointer. Here's a small sampling of optional accessories available from your local General International dealer. For more information about our products, please visit our website at [www.general.ca](http://www.general.ca)



## **DUST COLLECTORS**

Dust collectors contribute to a cleaner more healthful workshop environment.

We offer a wide selection of top quality dust collectors to suit all your shop needs.



## **Electronic Earmuffs**

**# 99-200**

Highly efficient noise reduction to help protect your hearing when operating power tools.



## **Magnetic micro-adjustable planer and jointer knife alignment gauge - # 30-025**

Keeps knives in perfect alignment, accurate to  $\pm 0.001"$ . Suitable for all planer and jointer knives from 6" - 26" in length. The easiest way to set planer and jointer knives.



## **Dial-gauge micrometer for knife alignment - # 30-050**

Precision built, easy to adjust, mounted on enamel finished alloy steel. Designed to rest squarely on the cutter head for fast accurate knife alignment. Dial is easy to read and adjust.



## **Jointer knife alignment Jig - # 30-075**

8 7/8" Alloy steel bars with 3 magnetic points for precise alignment of jointer knives. Assures perfect finished cuts to an accuracy of  $\pm 0.001"$  ( $\pm 0.025$  mm). Can be used on most jointer models.

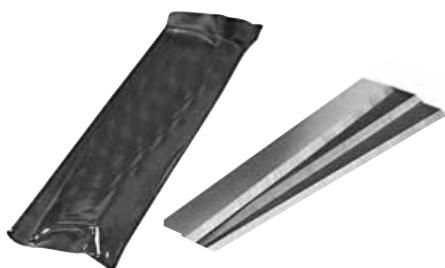
## **MAGNUM Helical cutter head - 100H**

4 rows, total: 16 inserts



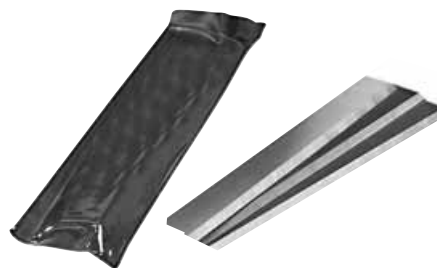
## **Replacement Jointer Knives - # 80-105**

Set of three 6" High Speed Steel jointer knives.

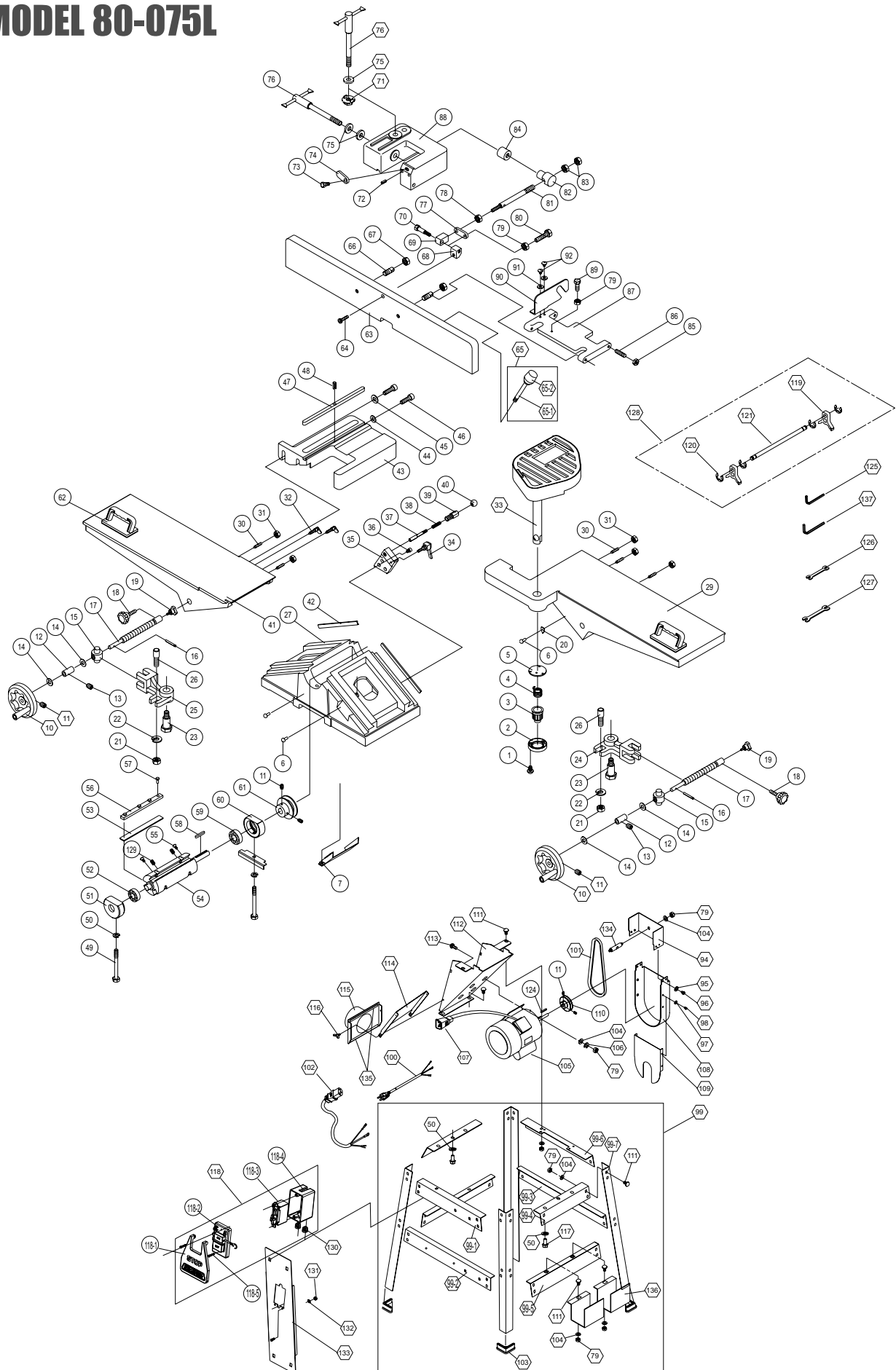


## **Replacement Jointer Knives - # 80-110**

Set of three 6" Carbide jointer knives.



# MODEL 80-075L



**PARTS LIST  
80-075L**

REF NO.	PART NO.	DESCRIPTION	SPECIFICATION	QTY
1	80100-01	PHILLIPS HEAD SCREW	5/32"-32NCX5/8"	3
2	80100-02	RETAINER		1
3	80100-03	SPRING KNOB		1
4	80100-04	SPRING		1
5	80100-05	RETAINING WASHER		1
6	80100-06	RIVET	2X5	5
7	80075-177	CHIP BREAKER		1
10	80100-10	HANDWHEEL		2
11	80100-11	SET SCREW	1/4"-20NCX3/8"	4
12	80100-12	BUSHING		2
13	80100-13	SET SCREW	5/16"-18NCX3/8"	2
14	80100-14	FLAT WASHER	10X22X0.8T	4
15	80100-15	ADJUSTING NUT		2
16	80100-16	SPRING PIN	3X25	2
17	80100-17	LEAD SCREW		2
18	80100-18	KNOB		2
19	80100-19	KNOB		2
20	80100-20	POINTER		1
21	80100-21	HEX. NUT	1/2"-12NC(19.05BX11.11H)	2
22	80100-22	LOCK WASHER	13X22.7	2
23	80100-23	PIVOT PIN		2
24	80100-24	FRONT BALL CRANK		1
25	80100-25	REAR BALL CRANK		1
26	80100-26	SHOULDER PIN		2
27	80100-27	BASE		1
29	80100-29	IN-FEED TABLE		1
30	80100-30	SET SCREW		5
31	80100-31	HEX. NUT	1/4"-20NC(11BX5.5H)	5
32	80100-32	LOCK SCREW	7/8" X 1/4" -20NC X 1"	2
33	80100-33	CUTTER GUARD		1
34	80100-34	LOCK LEVER		1
35	80100-35	FIXED PLATE		1
36	80100-36	CAP SCREW	5/16"-18NCX3/4"	3
37	80100-37	PIN		1
38	80100-38	SPRING		1
39	80100-39	SPRING SEAT		1
40	80100-40	BALL HANDLE		1
41	80100-41	OUT-FEED TABLE		1
42	80100-42	GIB		2
43	80100-43	FENCE BRACKET		1
44	80100-44	FLAT WASHER	10X20X3.0T	1
45	80100-45	FLAT WASHER	10.5X28X3.0T	1
46	80100-46	CAP SCREW	3/8"-16NCX1-1/2"	2
47	80100-47	GUIDE BAR	3/8" X 3/8" X 225	1
48	80100-48	SPRING PIN	4X20	1
49	80100-49	BOLT	3/8"-24NFX89MM	2
50	80100-50	LOCK WASHER	10.2X18.5	5
51	80100-51	BEARING HOUSING		1
52	80100-52	BEARING	6202-2NSE	1
53	80100-53	KNIFE		3
54	80100-54	CUTTER HEAD		1
55	80100-55	COUNTERSUNK SCREW	M5X0.8PX12	6
56	80100-56	KNIFE LOCK BAR		3
57	80100-57	KNIFE LOCK SCREW		12
58	80100-58	KEY	5X5X25	1

**PARTS LIST  
80-075L**

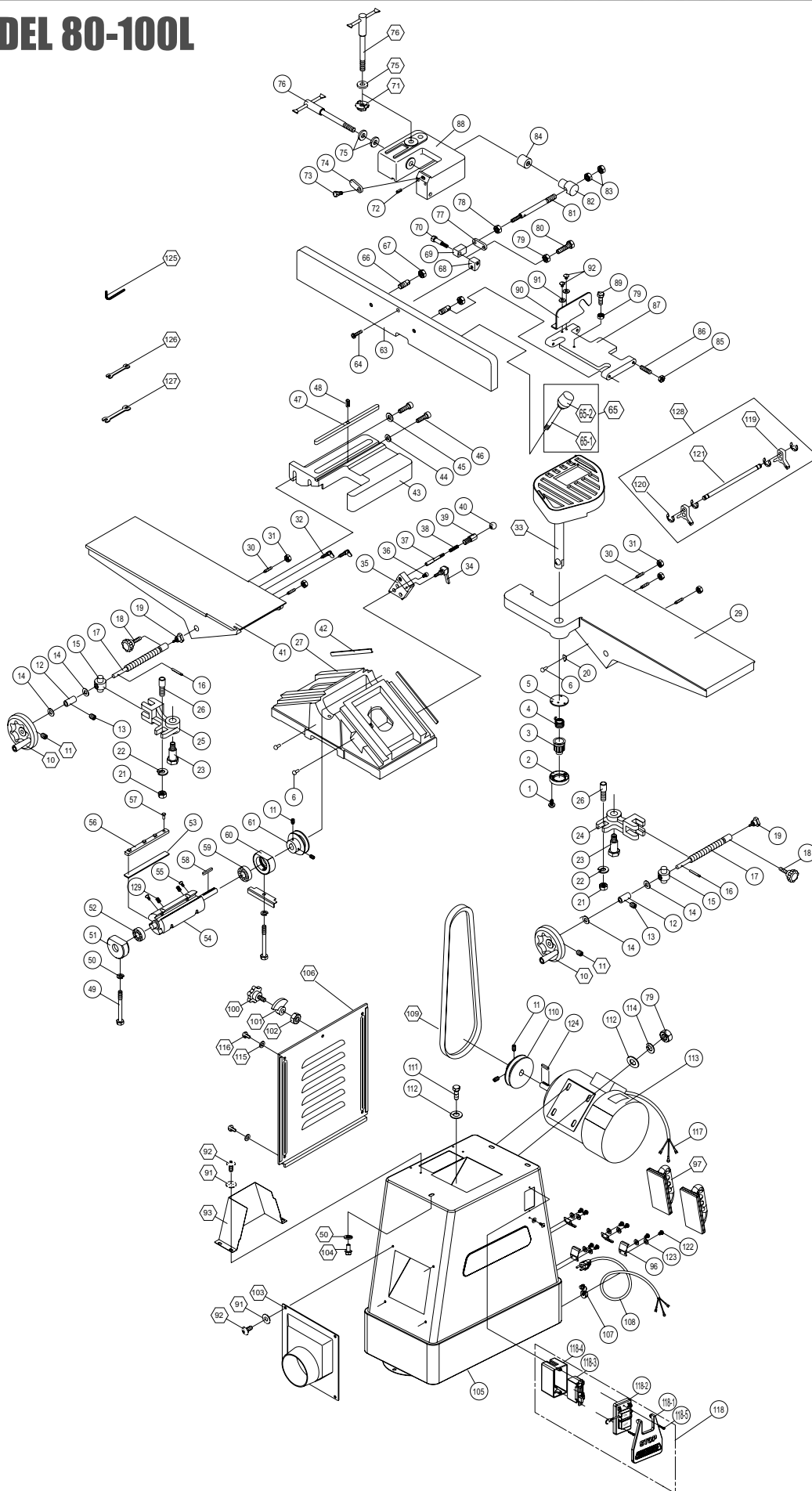
REF NO.	PART NO.	DESCRIPTION	SPECIFICATION	QTY
59	80100-59	BEARING	6203-2NSE	1
60	80100-60	BEARING HOUSING		1
61	80100-61	CUTTER HEAD PULLEY		1
62	80100-97	PUSH BLOCK		2
63	80100-63	FENCE BODY		1
64	80100-64	COUNTERSUNK SCREW	5/16"-18NCX1-5/8"	1
65	80100-65	FENCE HANDLE ASSEMBLY		1
65-1	80100-65-1	HANDLE SHAFT		1
65-2	80100-65-2	HANDLE KNOB		1
66	80100-66	FENCE LINKAGE		2
67	80100-67	HEX NUT	1/2"-20NF (19.05BX6.35H)	2
68	80100-68	BLOCK		1
69	80100-69	BLOCK		1
70	80100-70	BOLT		1
71	80100-71	LOCK NUT		1
72	80100-72	SPRING PIN	4X12	2
73	80100-73	HEX. HEAD BOLT		1
74	80100-74	STOP PLATE		1
75	80100-75	FLAT WASHER	13X28X3.0T	2
76	80100-76	FENCE LOCKING HANDLE		2
77	80100-77	STOP PLATE		1
78	80100-78	HEX. NUT	7/16"-14NC (17.4BX9.52H)	1
79	80100-79	HEX. NUT	5/16"-18NC (12.7BX6.75H)	40
80	80100-80	HEX. HEAD BOLT	5/16"-18NCX1-3/4"	1
81	80100-81	LINKAGE		1
82	80100-82	SWIVEL BLOCK		1
83	80100-83	HEX. NUT	5/8"-18NF (23.81BX8H)	2
84	80100-84	SPACER		1
85	80100-85	HEX. NUT	3/8"-16NC (14.2BX8.33H)	4
86	80100-86	SCREW		4
87	80100-87	LINK PLATE		1
88	80100-88	FENCE SLIDE BLOCK		1
89	80100-89	HEX. HEAD BOLT	5/16"-18NCX1"	1
90	80100-90	PLATE		1
91	80100-91	FLAT WASHER	6.6X13X1.0T	2
92	80100-92	PHILLIPS HEAD SCREW	1/4"-20NCX1/2"	2
94	80075-126	UPPER PULLEY GUARD		1
95	80075-127	FLAT WASHER	6.7X16X1.0T	4
96	80075-128	PHILLIPS HEAD SCREW	1/4"-20NCX3/8"	4
97	80075-129	FLAT WASHER	4.3X10X1.0T	4
98	80075-130	PHILLIPS HEAD SCREW	5/32"-32NCX1/4"	4
99	80075-176	STAND ASSEMBLY		1
99-1	80075-159	STAND FRONT TOP SHELF		1
99-2	80075-160	STAND FRONT CROSS BRACE		1
99-3	80075-158	STAND REAR CROSS BRACE		1
99-4	80075-162	SIDE TOP SHELF (LEFT AND RIGHT)		2
99-5	80075-161	SIDE CROSS BRACE (LEFT AND RIGHT)		2
99-6	80075-157	STAND REAR TOP SHELF		1
99-7	80075-156	STAND LEG		4
100	80075-148	POWER CORD		1
101	80075-154	V-BELT	A32	1
102	80075-146	SWITCH CORD	SJT 16AWGX3CX515MM	1
103	80075-164	RUBBER FOOT		4
104	80075-155	FLAT WASHER	8.5X16X1.8T	52
105	80100-113	MOTOR	1HPX110/220VX60HZX1PHX2PX14A/7A	1

## PARTS LIST 80-075L

REF NO.	PART NO.	DESCRIPTION	SPECIFICATION	QTY
106	80075-125	LOCK WASHER	8.2X15.4	4
107	80075-149	MOTOR CORD	SJT 16AWGX3CX358MM	1
108	80075-131	LOWER PULLEY GUARD COVER		1
109	80075-132	LOWER PULLEY GUARD BACKING PLATE		1
110	80100-110	MOTOR PULLEY		1
111	80075-133	CARRIAGE BOLT	5/16"-18NCX5/8"	42
112	80075-134	MOTOR MOUNTING BRACKET		1
113	80075-135	CARRIAGE BOLT	5/16"-18NCX20MM	4
114	80075-136	DUST HOOD COVER		1
115	80075-137	DUST HOOD OUTLET		1
116	80075-138	WING SCREW	M5X0.8PX12	2
117	80075-163	FLANGE BOLT	3/8"-16NCX3/4"	3
118	80100-118	SWITCH ASSEMBLY		1
118-1	80100-130	SWITCH PAD		1
118-2	80100-131	SWITCH FRONT COVER		1
118-3	80100-132	SWITCH BODY		1
118-4	80075-145	SWITCH BACK COVER		1
118-5	80100-134	PHILLIPS HEAD SCREW	M4X0.7PX25	2
119	80100-119	KNIFE SETTING GAUGE		2
120	80100-120	E RING	ETW-9	4
121	80100-121	KNIFE GAUGE BAR		1
124	80100-124	KEY	5X5X30	1
125	80100-125	ALLEN KEY	3MM	1
126	80100-126	OPEN WRENCH	8 - 10 MM	1
127	80100-127	OPEN WRENCH	12 -14 MM	1
128	80100-128	KNIFE SETTING GAUGE ASS'Y		1
129	80100-129	SPRING		6
130	80075-167	STRAIN RELIEF		2
131	80075-168	NUT	3/16" X24NC	1
132	80075-169	SPROCKET WASHER	BW-5	1
133	80075-143	SWITCH PLATE		1
134	80075-153	STUD/SPACER		1
135	80075-147	SPONGE GASKET		2
136	80075-178	PUSH BLOCK STORAGE BRACKET		2
137	80075-179	ALLEN KEY	4MM	1

## Notes

# MODEL 80-100L



**PARTS LIST  
80-100L**

REF NO.	PART NO.	DESCRIPTION	SPECIFICATION	QTY
1	80100-01	PHILLIPS HEAD SCREW	5/32"-32NCX5/8"	3
2	80100-02	RETAINER		1
3	80100-03	SPRING KNOB		1
4	80100-04	SPRING		1
5	80100-05	RETAINING WASHER		1
6	80100-06	RIVET	2X5	5
10	80100-10	HANDWHEEL		2
11	80100-11	SET SCREW	1/4"-20NCX3/8"	4
12	80100-12	BUSHING		2
13	80100-13	SET SCREW	5/16"-18NCX3/8"	2
14	80100-14	FLAT WASHER	10X22X0.8T	4
15	80100-15	ADJUSTING NUT		2
16	80100-16	SPRING PIN	3X25	2
17	80100-17	LEAD SCREW		2
18	80100-18	KNOB		2
19	80100-19	KNOB		2
20	80100-20	POINTER		1
21	80100-21	HEX. NUT	1/2"-12NC(19.05BX11.11H)	2
22	80100-22	LOCK WASHER	13X22.7	2
23	80100-23	PIVOT PIN		2
24	80100-24	FRONT BALL CRANK		1
25	80100-25	REAR BALL CRANK		1
26	80100-26	SHOULDER PIN		2
27	80100-27	BASE		1
29	80100-29	IN-FEED TABLE		1
30	80100-30	SET SCREW		5
31	80100-31	HEX. NUT	1/4"-20NC(11BX5.5H)	5
32	80100-32	LOCK SCREW	7/8" X 1/4" -20NC X 1"	2
33	80100-33	CUTTER GUARD		1
34	80100-34	LOCK LEVER		1
35	80100-35	FIXED PLATE		1
36	80100-36	CAP SCREW	5/16"-18NCX3/4"	3
37	80100-37	PIN		1
38	80100-38	SPRING		1
39	80100-39	SPRING SEAT		1
40	80100-40	BALL HANDLE		1
41	80100-41	OUT-FEED TABLE		1
42	80100-42	GIB		2
43	80100-43	FENCE BRACKET		1
44	80100-44	FLAT WASHER	10X20X3.0T	1
45	80100-45	FLAT WASHER	10.5X28X3.0T	1
46	80100-46	CAP SCREW	3/8"-16NCX1-1/2"	2
47	80100-47	GUIDE BAR	3/8" X 3/8" X 225	1
48	80100-48	SPRING PIN	4X20	1
49	80100-49	BOLT	3/8"-24NFX89MM	2
50	80100-50	LOCK WASHER	10.2X18.5	5
51	80100-51	BEARING HOUSING		1
52	80100-52	BEARING	6202-2NSE	1
53	80100-53	KNIFE		3
54	80100-54	CUTTER HEAD		1
55	80100-55	COUNTERSUNK SCREW	M5X0.8PX12	6
56	80100-56	KNIFE LOCK BAR		3
57	80100-57	KNIFE LOCK SCREW		12
58	80100-58	KEY	5X5X25	1
59	80100-59	BEARING	6203-2NSE	1

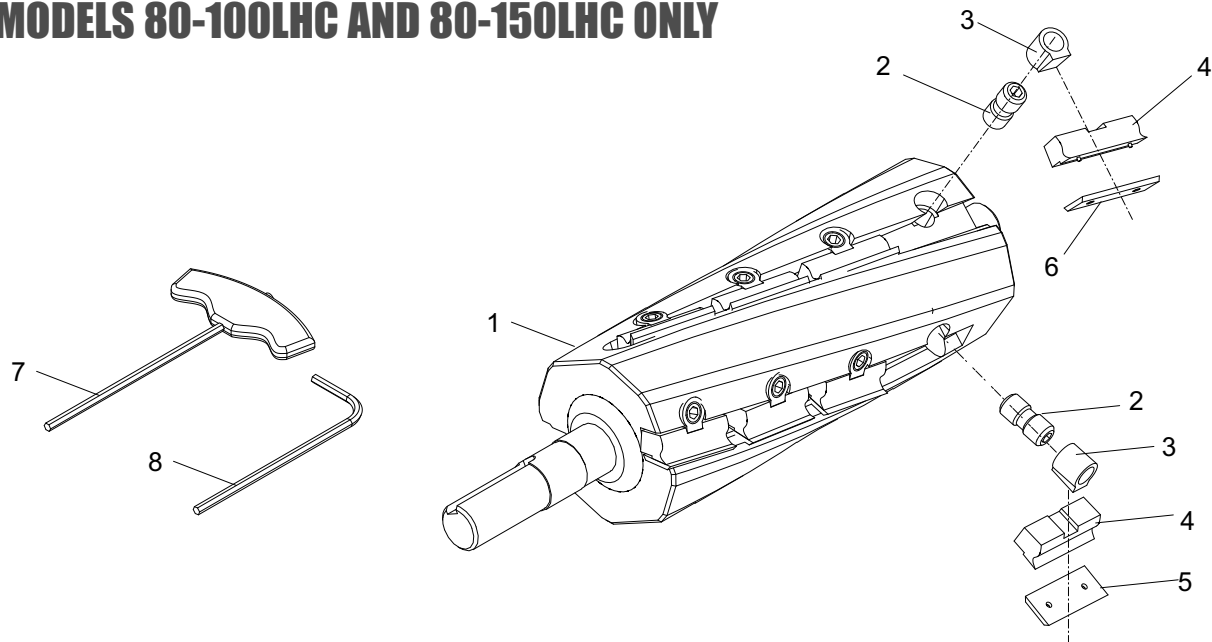
# **PARTS LIST** **80-100L**

REF NO.	PART NO.	DESCRIPTION	SPECIFICATION	QTY
60	80100-60	BEARING HOUSING		1
61	80100-61	CUTTER HEAD PULLEY		1
62	80100-97	PUSH BLOCK		2
63	80100-63	FENCE BODY		1
64	80100-64	COUNTERSUNK SCREW	5/16"-18NCX1-5/8"	1
65	80100-65	FENCE HANDLE ASSEMBLY		1
65-1	80100-65-1	HANDLE SHAFT		1
65-2	80100-65-2	HANDLE KNOB		1
66	80100-66	FENCE LINKAGE		2
67	80100-67	HEX NUT	1/2"-20NF (19.05BX6.35H)	2
68	80100-68	BLOCK		1
69	80100-69	BLOCK		1
70	80100-70	BOLT		1
71	80100-71	LOCK NUT		1
72	80100-72	SPRING PIN	4X12	2
73	80100-73	HEX. HEAD BOLT		1
74	80100-74	STOP PLATE		1
75	80100-75	FLAT WASHER	13X28X3.0T	2
76	80100-76	FENCE LOCKING HANDLE		2
77	80100-77	STOP PLATE		1
78	80100-78	HEX. NUT	7/16"-14NC (17.4BX9.52H)	1
79	80100-79	HEX. NUT	5/16"-18NC (12.7BX6.75H)	40
80	80100-80	HEX. HEAD BOLT	5/16"-18NCX1-3/4"	1
81	80100-81	LINKAGE		1
82	80100-82	SWIVEL BLOCK		1
83	80100-83	HEX. NUT	5/8"-18NF (23.81BX8H)	2
84	80100-84	SPACER		1
85	80100-85	HEX. NUT	3/8"-16NC (14.2BX8.33H)	4
86	80100-86	SCREW		4
87	80100-87	LINK PLATE		1
88	80100-88	FENCE SLIDE BLOCK		1
89	80100-89	HEX. HEAD BOLT	5/16"-18NCX1"	1
90	80100-90	PLATE		1
91	80100-91	FLAT WASHER	6.6X13X1.0T	2
92	80100-92	PHILLIPS HEAD SCREW	1/4"-20NCX1/2"	2
93	80100-93	PULLEY COVER		1
96	80100-96	PUSH BLOCK STORAGE BRACKET		4
97	80100-97	PUSH BLOCK		2
100	80100-100	KNOB		1
101	80100-101	DOOR LATCH		1
102	80100-102	HEX. NUT	3/8"-16NC(14.2BX8.33H)	1
103	80100-103	DUST PORT		1
104	80100-104	FLANGE BOLT	3/8"-16NCX3/4"	3
105	80100-105	STAND		1
106	80100-106	DOOR		1
107	80100-107	CORD RETAINER	SB7R-1	1
108	80100-108	POWER CORD		1
109	80100-109	V BELT	A36	1
110	80100-110	MOTOR PULLEY		1
111	80100-111	HEX. HEAD BOLT	5/16"-18NCX3/4"	4
112	80100-112	FLAT WASHER	8.5X23X2.0T	8
113	80100-113	MOTOR	1HPX110/220VX60HZX1PHX2P	1
114	80100-114	LOCK WASHER	8.2X15.4	4
115	80100-115	FLAT WASHER	4.3X10X1.0T	4
116	80100-116	PHILLIPS HEAD SCREW	1/8"-40NCX3/8"	4

## PARTS LIST 80-100L

REF NO.	PART NO.	DESCRIPTION	SPECIFICATION	QTY
117	80100-117	MOTOR WIRE	SJT16AWGX3CX700MM	1
118	80100-118	SWITCH ASSEMBLY		1
118-1	80100-130	SWITCH PAD		1
118-2	80100-131	SWITCH FRONT COVER		1
118-3	80100-132	SWITCH BODY		1
118-4	80075-145	SWITCH BACK COVER		1
118-5	80100-134	PHILLIPS HEAD SCREW	M4X0.7PX25	2
119	80100-119	KNIFE SETTING GAUGE BLOCK		2
120	80100-120	E RING	ETW-9	4
121	80100-121	KNIFE GAUGE BAR		1
124	80100-124	KEY	5X5X30	1
125	80100-125	ALLEN KEY	3MM	1
126	80100-126	OPEN WRENCH	8 - 10 MM	1
127	80100-127	OPEN WRENCH	12 -14 MM	1
128	80100-128	KNIFE SETTING GAUGE ASS'Y		1
129	80100-129	SPRING		6

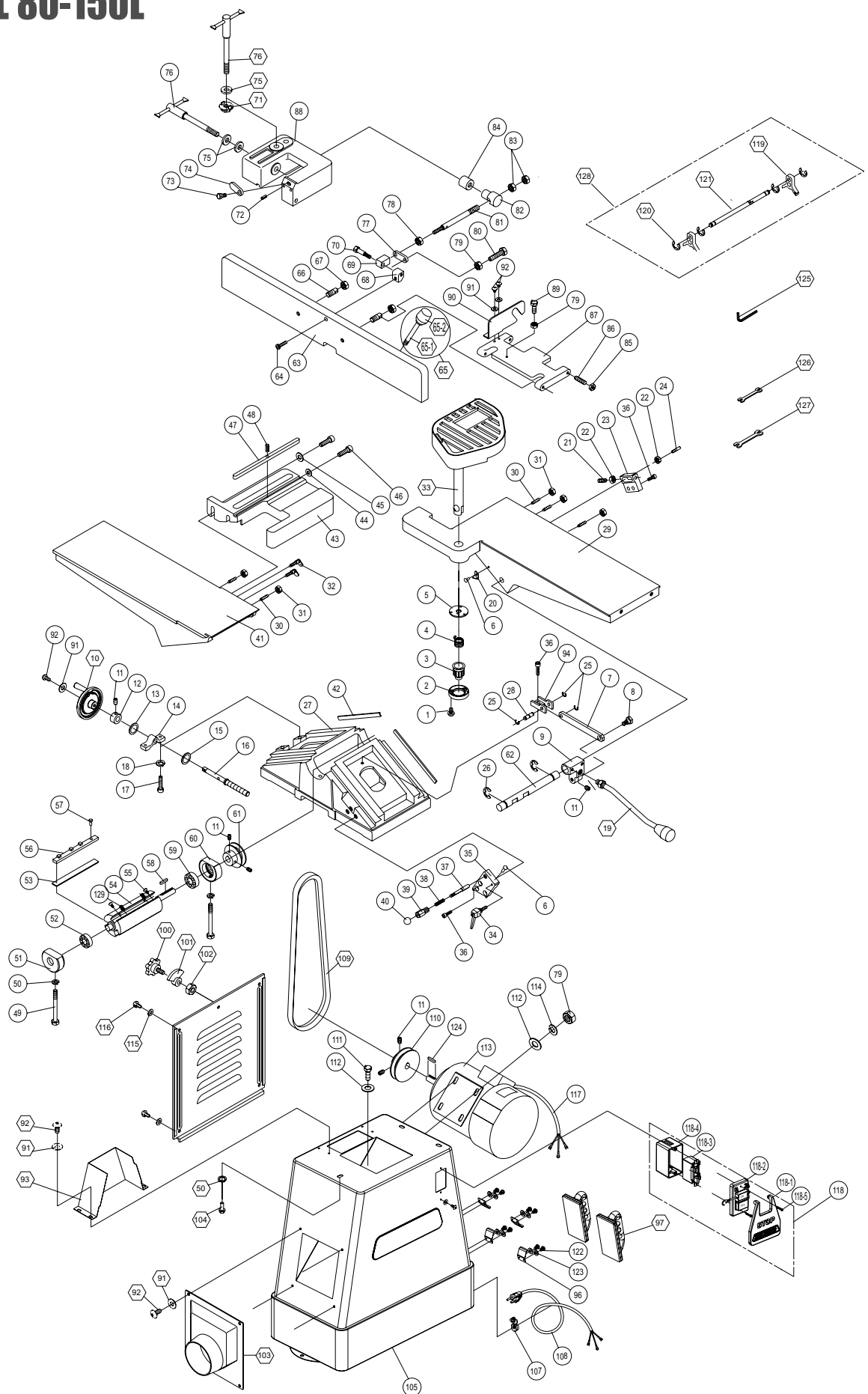
## HELICAL CUTTER HEAD - 100H MODELS 80-100LHC AND 80-150LHC ONLY



## PARTS LIST 80-100LHC / 80-150LHC

REF NO.	PART NO.	DESCRIPTION	SPECIFICATION	QTY
1	100H-01	CUTTER HEAD		1
2	100H-02	SCREW		16
3	100H-03	NUT		16
4	100H-04	KNIFE-HOLDER / CHIP-BREAKER		16
5	30-443	CARBIDE INSERT (STANDARD)	30X12X1.5MM (T)	14
6	100H-06	CARBIDE INSERT (RABBETING)	30X12X1.5MM (T)	2
7	100H-07	T HANDLE ALLEN KEY	5MM	1
8	100H-08	ALLEN KEY	5MM	1

# MODEL 80-150L



**PARTS LIST  
80-150L**

REF NO.	PART NO.	DESCRIPTION	SPECIFICATION	QTY
1	80100-01	PHILLIPS HEAD SCREW	5/32"-32NCX5/8"	3
2	80100-02	RETAINER		1
3	80100-03	SPRING KNOB		1
4	80100-04	SPRING		1
5	80100-05	RETAINING WASHER		1
6	80100-06	RIVET	2X5	5
7	80150-58	LINKAGE		1
8	80150-59	BOLT		1
9	80150-61	ADJUSTING BLOCK		1
10	80150-72	HANDWHEEL		1
11	80100-11	SET SCREW	1/4"-20NCX3/8"	7
12	80150-50	BUSHING		1
13	80150-44	WAVE WASHER	12.6X16.8	1
14	80150-52	BRACKET		1
15	80150-51	BRASS WASHER		1
16	80150-53	LEAD SCREW		1
17	80150-40	CAP SCREW	5/16"-18NC*2"	2
18	80150-43	LOCK WASHER	8.2*15.4	2
19	80150-71	HANDLE		1
20	80100-20	POINTER		1
21	80150-63	SET SCREW	5/16"-18NC*3/4"	2
22	80150-64	HEX. NUT	5/16"-18NC	3
23	80150-65	FIXING PLATE		1
24	80150-67	PIN		1
25	80150-45	E RING	ETW-6	3
26	80150-46	E RING	ETW-12	2
27	80150-55	BASE		1
28	80150-56	SHAFT		1
29	80150-54	IN-FEED TABLE		1
30	80100-30	SET SCREW		5
31	80100-31	HEX. NUT	1/4"-20NC(11BX5.5H)	5
32	80100-32	LOCK SCREW	7/8" X 1/4" -20NC X 1"	2
33	80100-33	CUTTER GUARD		1
34	80100-34	LOCK LEVER		1
35	80150-73	FIXED PLATE		1
36	80100-36	CAP SCREW	5/16"-18NCX3/4"	6
37	80100-37	PIN		1
38	80100-38	SPRING		1
39	80100-39	SPRING SEAT		1
40	80100-40	BALL HANDLE		1
41	80150-49	OUT-FEED TABLE		1
42	80100-42	GIB		2
43	80100-43	FENCE BRACKET		1
44	80100-44	FLAT WASHER	10X20X3.0T	1
45	80100-45	FLAT WASHER	10.5X28X3.0T	1
46	80100-46	CAP SCREW	3/8"-16NCX1-1/2"	2
47	80100-47	GUIDE BAR	3/8" X 3/8" X 225	1
48	80100-48	SPRING PIN	4X20	1
49	80100-49	BOLT	3/8"-24NFX89MM	2
50	80100-50	LOCK WASHER	10.2X18.5	5
51	80100-51	BEARING HOUSING		1
52	80100-52	BEARING	6202-2NSE	1
53	80100-53	KNIFE		3
54	80100-54	CUTTER HEAD		1
55	80100-55	COUNTERSUNK SCREW	M5X0.8PX12	6

# **PARTS LIST** **80-150L**

REF NO.	PART NO.	DESCRIPTION	SPECIFICATION	QTY
56	80100-56	KNIFE LOCK BAR		3
57	80100-57	KNIFE LOCK SCREW		12
58	80100-58	KEY	5X5X25	1
59	80100-59	BEARING	6203-2NSE	1
60	80100-60	BEARING HOUSING		1
61	80100-61	CUTTER HEAD PULLEY		1
62	80150-60	SHAFT		1
63	80100-63	FENCE BODY		1
64	80100-64	COUNTERSUNK SCREW	5/16"-18NCX1-5/8"	1
65	80100-65	FENCE HANDLE ASSEMBLY		1
65-1	80100-65-1	HANDLE SHAFT		1
65-2	80100-65-2	HANDLE KNOB		1
66	80100-66	FENCE LINKAGE		2
67	80100-67	HEX NUT	1/2"-20NF (19.05BX6.35H)	2
68	80100-68	BLOCK		1
69	80100-69	BLOCK		1
70	80100-70	BOLT		1
71	80100-71	LOCK NUT		1
72	80100-72	SPRING PIN	4X12	2
73	80100-73	HEX. HEAD BOLT		1
74	80100-74	STOP PLATE		1
75	80100-75	FLAT WASHER	13X28X3.0T	2
76	80100-76	FENCE LOCKING HANDLE		2
77	80100-77	STOP PLATE		1
78	80100-78	HEX. NUT	7/16"-14NC (17.4BX9.52H)	1
79	80100-79	HEX. NUT	5/16"-18NC (12.7BX6.75H)	6
80	80100-80	HEX. HEAD BOLT	5/16"-18NCX1-3/4"	1
81	80100-81	LINKAGE		1
82	80100-82	SWIVEL BLOCK		1
83	80100-83	HEX. NUT	5/8"-18NF (23.81BX8H)	2
84	80100-84	SPACER		1
85	80100-85	HEX. NUT	3/8"-16NC (14.2BX8.33H)	4
86	80150-37	TAPPER SCREW		4
87	80100-87	LINK PLATE		1
88	80100-88	FENCE SLIDE BLOCK		1
89	80100-89	HEX. HEAD BOLT	5/16"-18NCX1"	1
90	80100-90	PLATE		1
91	80100-91	FLAT WASHER	6.6X13X1.0T	9
92	80100-92	PHILLIPS HEAD SCREW	1/4"-20NCX1/2"	8
93	80100-93	PULLEY COVER		1
94	80150-57	BRACKET		1
96	80100-96	PUSH BLOCK STORAGE BRACKET		4
97	80100-97	PUSH BLOCK		2
100	80100-100	KNOB		1
101	80100-101	DOOR LATCH		1
102	80100-102	HEX. NUT	3/8"-16NC(14.2BX8.33H)	1
103	80100-103	DUST CHUTE		1
104	80100-104	CAP SCREW	3/8"-16NCX3/4"	3
105	80100-105	STAND		1
106	80100-106	DOOR		1
107	80100-107	CORD RETAINER	SB7R-1	1
108	80100-108	POWER CORD		1
109	80100-109	V BELT	A36	1
110	80100-110	MOTOR PULLEY		1
111	80100-111	HEX. HEAD BOLT	5/16"-18NCX3/4"	4

## PARTS LIST 80-150L

REF NO.	PART NO.	DESCRIPTION	SPECIFICATION	QTY
112	80100-112	FLAT WASHER	8.5X23X2.0T	8
113	80100-113	MOTOR	1HPX110/220VX60HZX1PHX2P	1
114	80100-114	LOCK WASHER	8.2X15.4	4
115	80100-115	FLAT WASHER	4.3X10X1.0T	4
116	80100-116	PHILLIPS HEAD SCREW	1/8"-40NCX3/8"	4
117	80100-117	MOTOR WIRE	SJT16AWGX3CX700MM	1
118	80100-118	SWITCH ASSEMBLY		1
118-1	80100-130	SWITCH PAD		1
118-2	80100-131	SWITCH FRONT COVER		1
118-3	80100-132	SWITCH BODY		1
118-4	80075-145	SWITCH BACK COVER		1
118-5	80100-134	PHILLIPS HEAD SCREW	M4X0.7PX25	2
119	80100-119	KNIFE SETTING GAUGE		2
120	80100-120	E RING	ETW-9	4
121	80100-121	KNIFE GAUGE BAR		1
124	80100-124	KEY	5X5X30	1
125	80100-125	ALLEN KEY	3MM	1
126	80100-126	OPEN WRENCH	8 - 10 MM	1
127	80100-127	OPEN WRENCH	12 -14 MM	1
128	80100-128	KNIFE SETTING GAUGE ASS'Y		1
129	80100-129	SPRING		6

## Notes

## Notes

**MODELS 80-075L - 80-100L/LHC - 80-150L/LHC**



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**IMPORTANT**

**When ordering replacement parts, always give the model number, serial number of the machine and part number. Also a brief description of each item and quantity desired.**